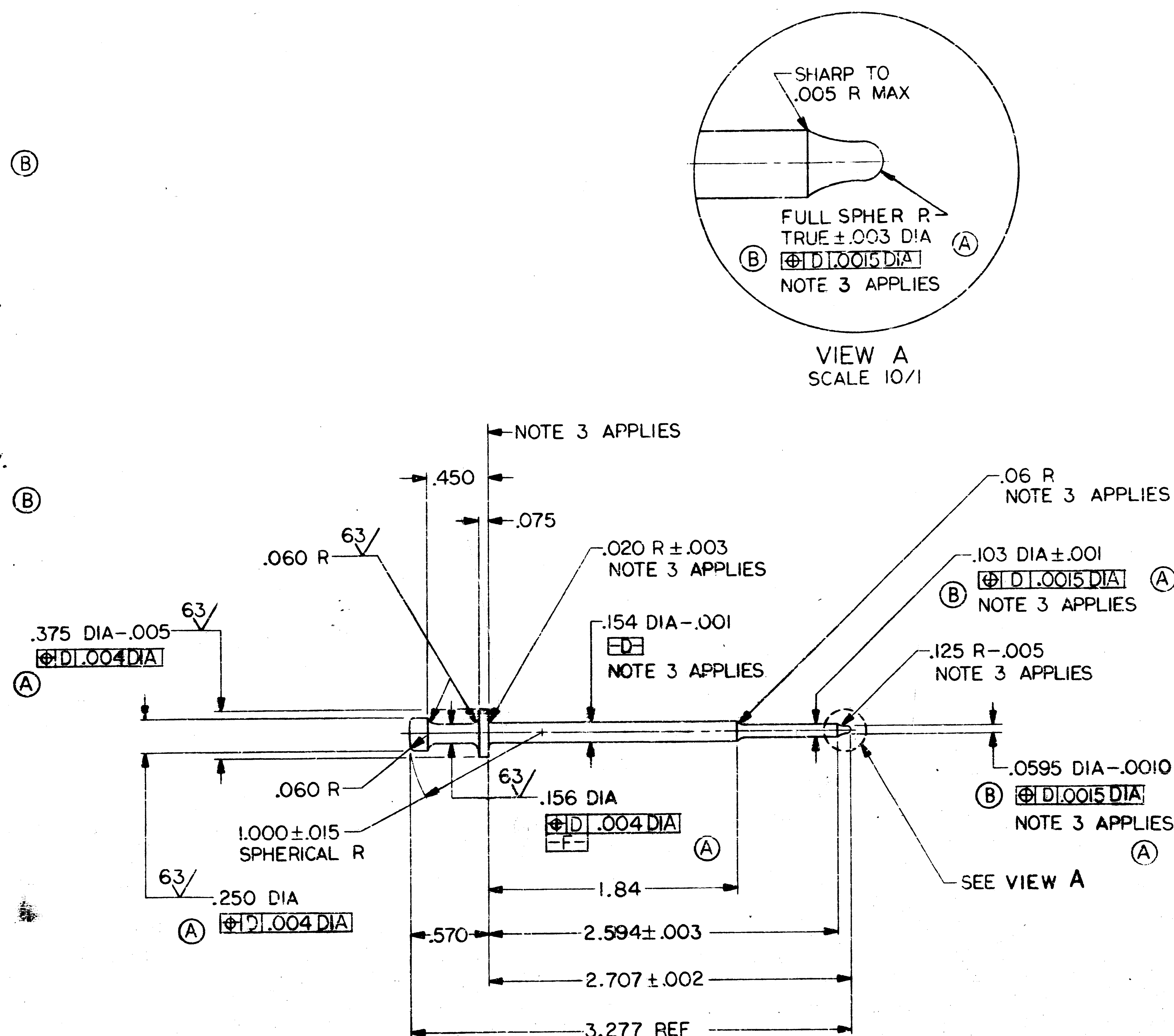


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NECESSARY FOR US AND ONLY IN CONNECTION WITH THE PREPARATION AND/OR SUBMISSION OF
BIDS OR PROPOSALS RELATED TO A PROCUREMENT BEING EFFECTED BY THE UNITED STATES GOVERNMENT
IN CONNECTION WITH THE MANUFACTURE, IN THE UNITED STATES EITHER BY THE UNITED STATES
GOVERNMENT OR UNDER A CONTRACT WITH THE UNITED STATES GOVERNMENT. THIS DOCUMENT IS CONTRACTING
DOCUMENT IN ACCORDANCE WITH THE RULES AND REGULATIONS GOVERNING THE ACQUISITION OF
EQUIPMENT OF THE ARMY FOR WHICH IT WAS PREPARED.

1. STEEL, CARPENTER 5-317; AISI 8640 OR AISI 8740. MATERIAL SHALL BE GUN QUALITY, ANNEALED TO A BRINNEL RANGE OF 187 TO 229. MEAN BRINNEL RANGE 210.
2. SUGGESTED HEAT TREAT PROCEDURE:
FOR CARPENTER 5-317;
HEAT IN NEUTRAL SALT BATH AT $1525^{\circ}\text{F} \pm 10^{\circ}$.
QUENCH IN SALT BATH AT $605^{\circ}\text{F} \pm 5^{\circ}$ HOLD
AT HEAT 18 TO 20 MINUTES. AIR COOL.
FOR AISI 8640 AND AISI 8740;
SAME PROCEDURE AS ABOVE EXCEPT
QUENCH TEMPERATURE IS $585^{\circ}\text{F} \pm 5^{\circ}$.
3. GRIND AFTER HEAT TREAT. ALL GROUND SURFACES, INCLUDING RADII AND FILLETS, $32\sqrt{}$.
4. FINISH 1.2.2.4 OF MIL-STD-171. FILM THICKNESS .0002 / .0003. CLAMP ELECTRODES ON DIA F. UNPLATED CONTACT AREA NOT TO EXCEED .06 DIA.
5. ALL DIMENSIONS APPLY BEFORE FINISH.
6. BREAK SHARP EDGES .005+.010.
7. MIL-W-13855 APPLIES.



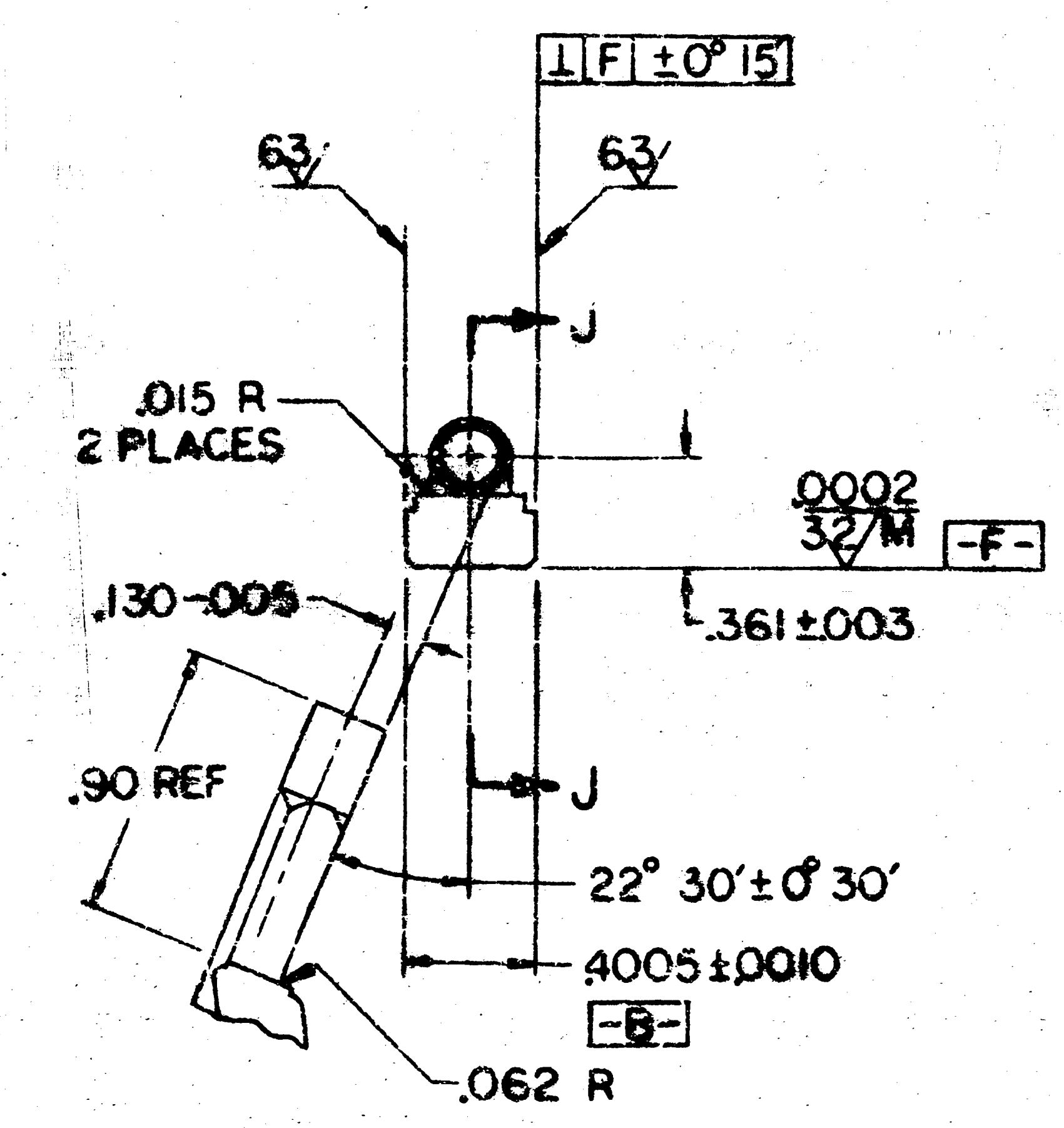
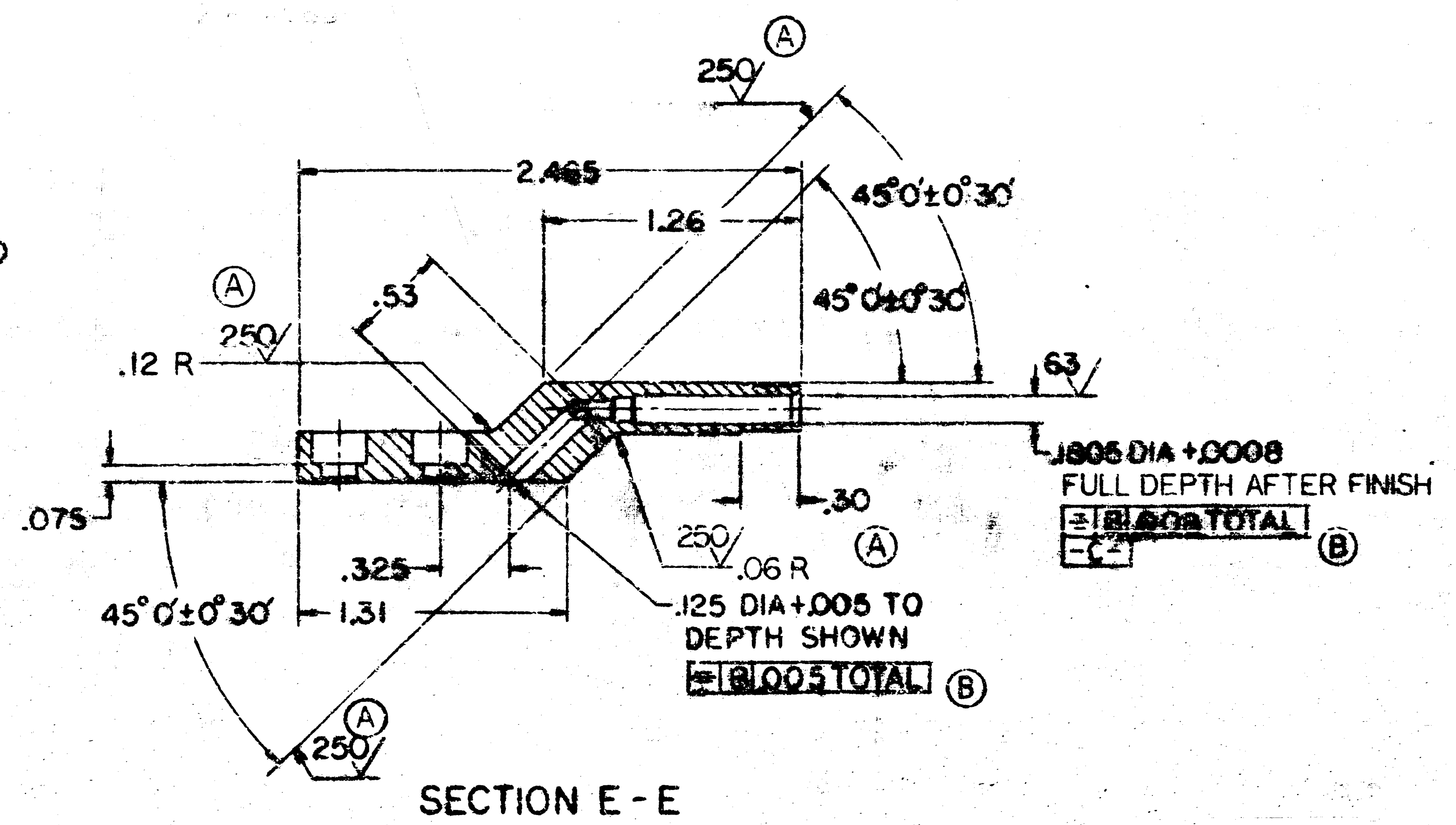
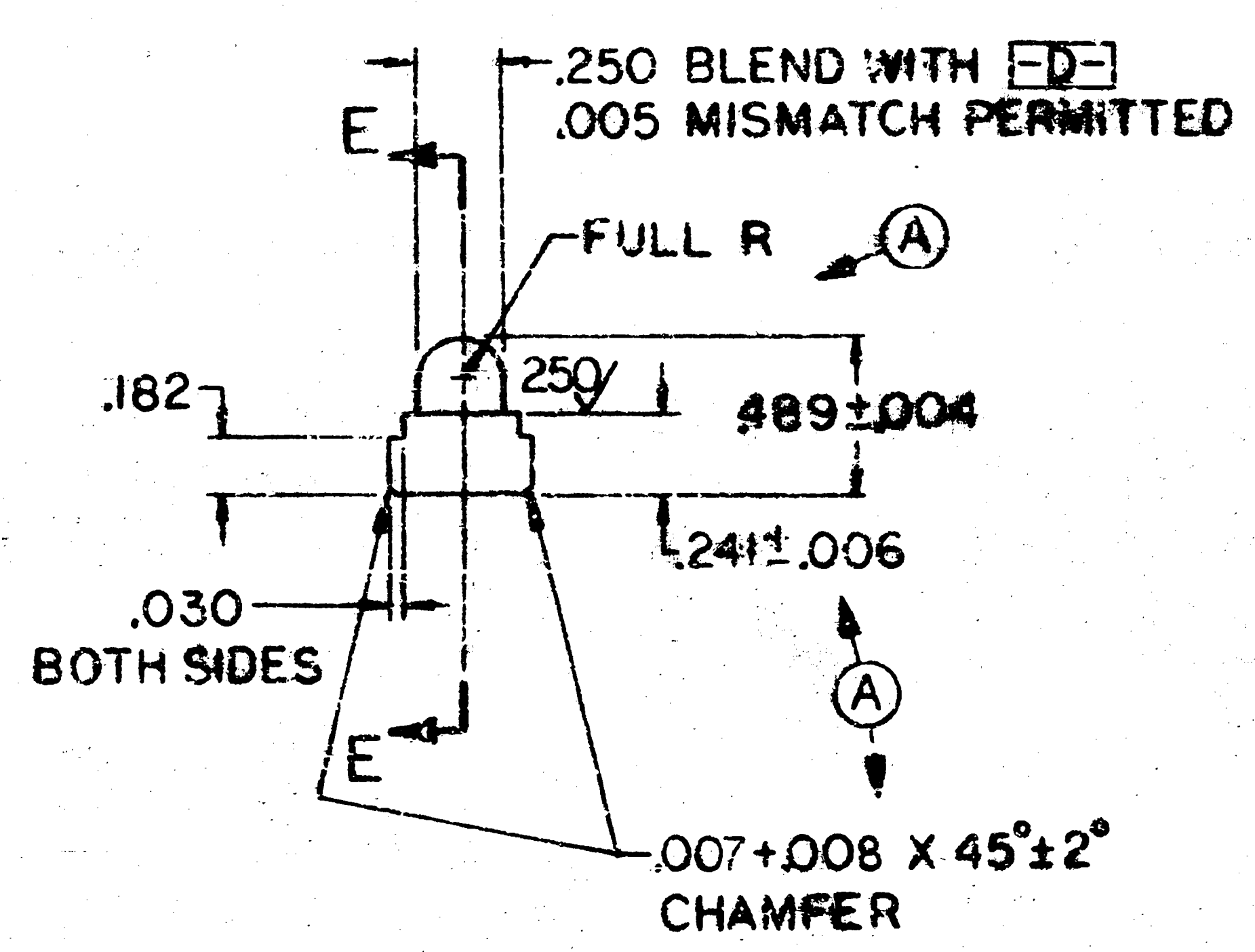
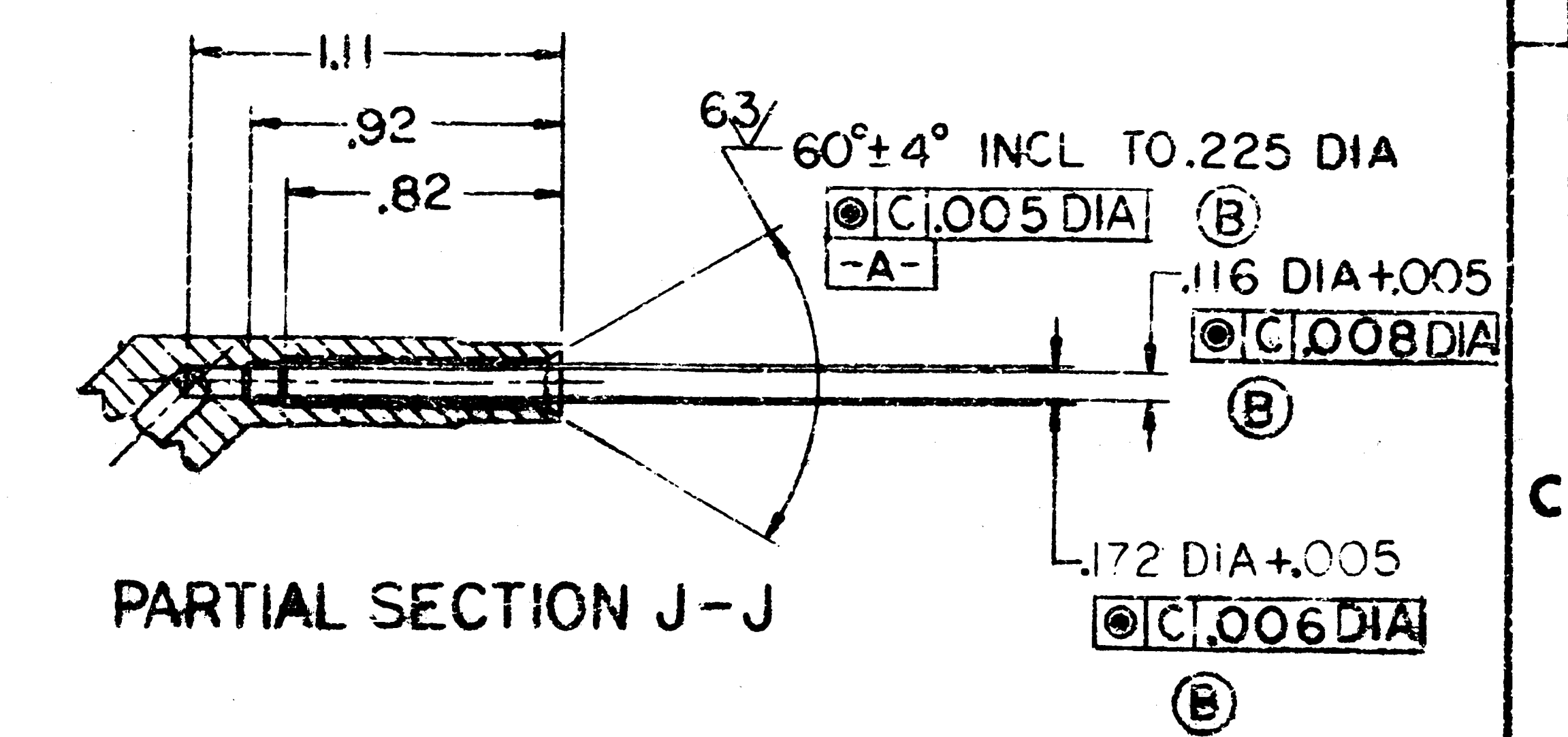
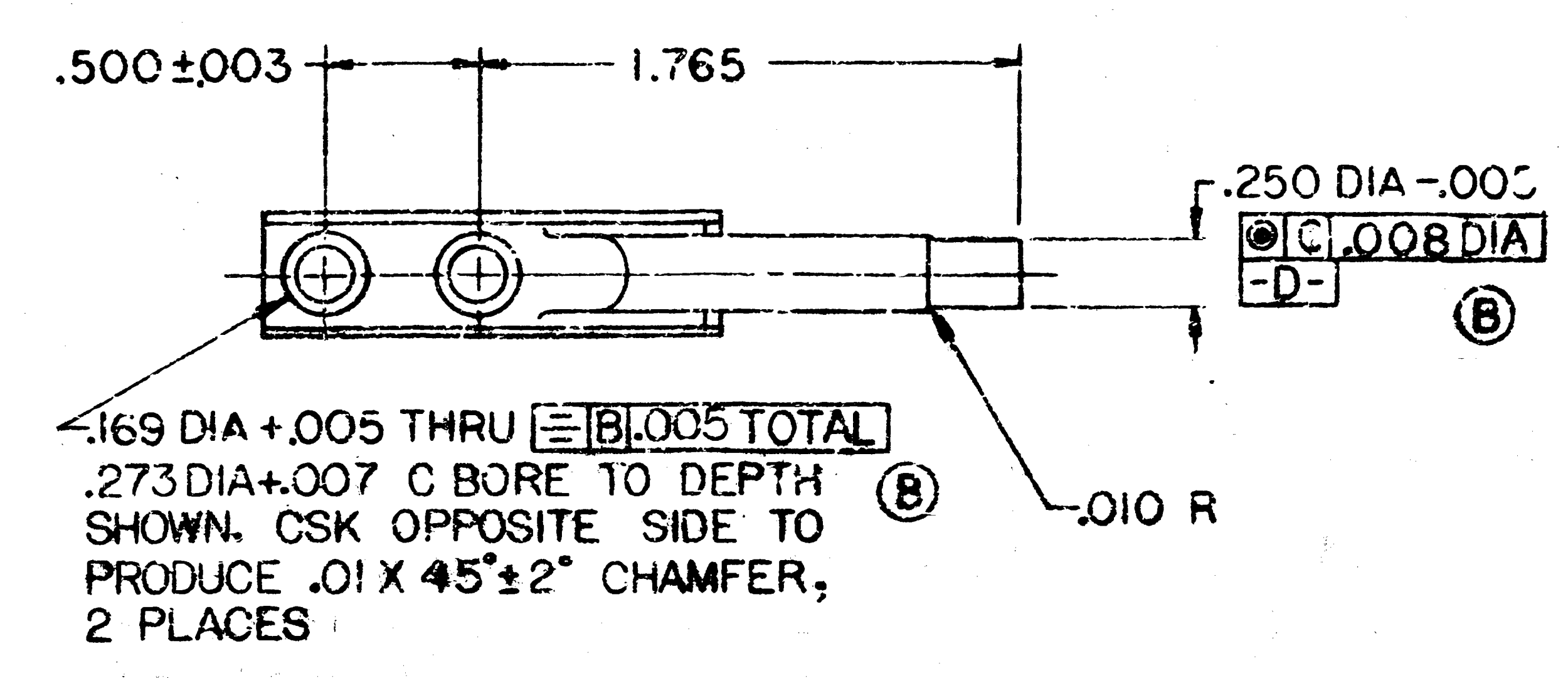
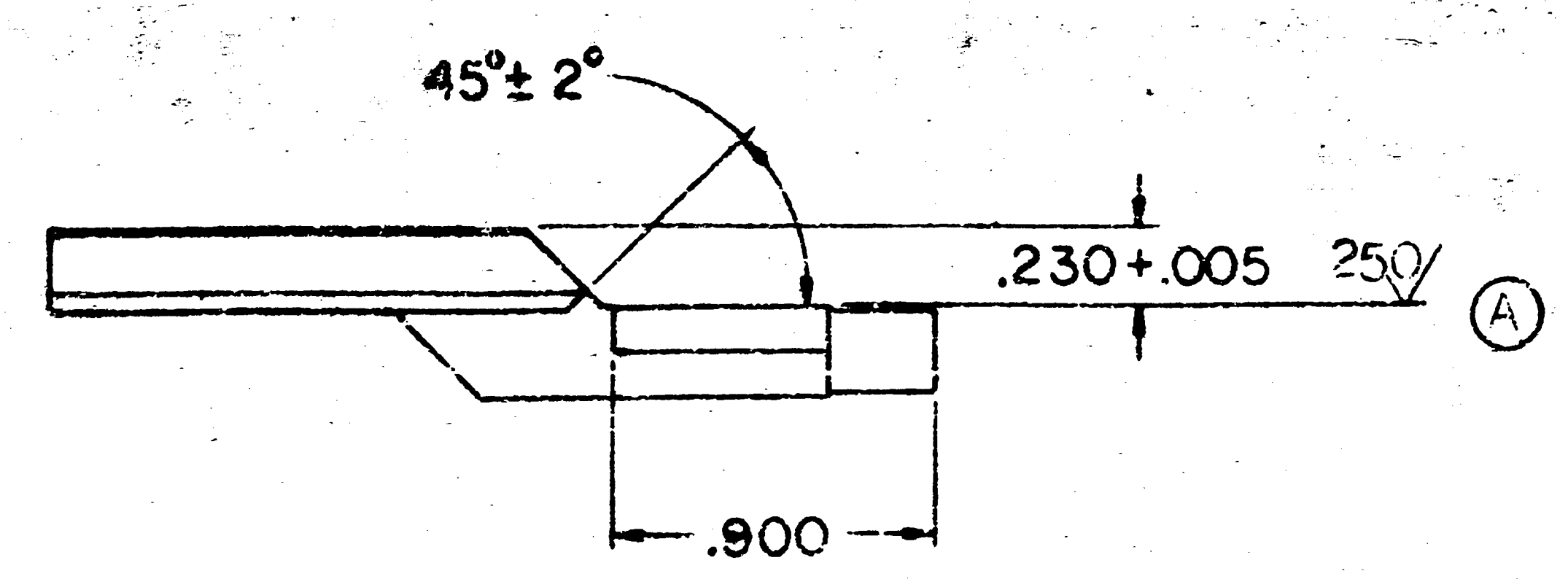
REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROV
			REDRAWN FROM COLT'S DRAWING D62294 REVISION B	27 APR 70	
		A	07SEE ERR HQR 20778	6 OCT 72	R.C.
		B	(1) SEE ERR HQR 30316	12 MAR 74	R.C.
		C	NOR W952009 80-02-13	80-05-16	R.C.
		D	ERR 201285AU (ECP G083111, 90-07-05)	20-07-25	R.C.
		E	NOR G152018/910708	310111	R.C.

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS		TOLERANCES:		DATE 27 APR 1970		PIN, FIRING	
MIN		ANGLES ±		PREPARED <i>JTC</i>			
MAX		3 PLACE DECIMALS ±.005		CHECKED <i>JTC</i>			
EL2		2 PLACE DECIMALS ±.01		ENGINEER <i>JTC</i>			
RA		MATERIAL		SUBMITTED <i>J.P. Hubbard</i>		SIZE CODE IDENT NO. DRAWING NO.	
BH		SEE NOTE 1		APPROVED <i>J.P. Hubbard</i>		D 19204 8448503	
RH		FINAL PROTECTIVE PIN SH		SCALE 2/1		SHEET OF	
C45-43		SEE NOTE 4					
APPLICATION							

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- NOTE:
1. FINISH 125/ EXCEPT AS NOTED.
 2. SUGGESTED HEAT TREAT PROCEDURE:
OIL QUENCH FROM 1575°F. TEMPER
AT 1100°F FOR 1 HOUR.
 3. FINISH 1.22.2 OF MIL-STD-171 ON DIA (C)
[A] AND [C]. FILM THICKNESS
.002/.003.
 4. ALL OTHER SURFACES TO RECEIVE
FINISH 5.3.1.2 OF MIL-STD-171.
 5. BREAK SHARP EDGES .005+.010.
 6. MIL-W-13855 APPLIES. (A)



CURRENT DESIGN ACTIVITY FSCM NO. 19200
U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ANGLES		CONTRACT NO.	
YS MIN		3 PLACE DECIMALS ±.005		DATE	27 APR 1970
YS MAX		2 PLACE DECIMALS ±.01		PREPARED BY	DAI/H
EL 2				CHECKED BY	DAI/H
RA				ENGINEER	DAI/H
BH				SUBMITTED BY	DAI/H
RH	C26-32			APPROVED BY	DAI/H
		APPLICATION	SEE NOTES 3&4		

DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
KEY, BOLT CARRIER	
SIZE CODE IDENT NO.	D 19204
DRAWING NO.	8448506
SCALE	2/1
SHEET	OF

D8448506

4 3 2 1

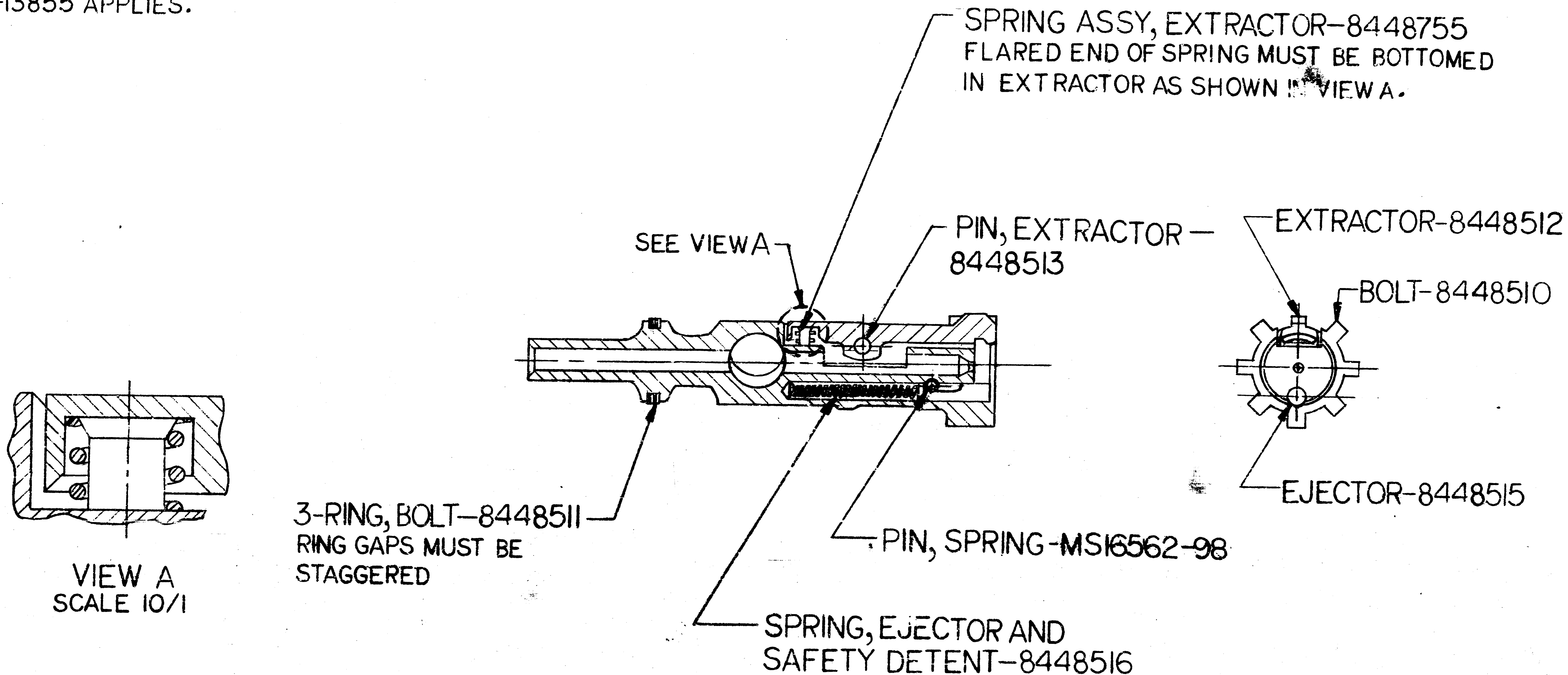
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REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
1		D	REPLACES REV C W/CHANGE SEE ERR HQR 20778	6 OCT 72	RE
		E	NORW2S0020 82-06-09	83-02-03	LAH RLD
		F	NOR W2S 0026 / 82-05-21	83-09-22	LAH RLD

NOTES:

I. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY FSCM No. 19200
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448509

SEE PL-8448509

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO:		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MIN		TOLERANCES:		DATE 27 APR 1970		BOLT ASSEMBLY	
YS MAX		ANGLES ±		PREPARED <i>[Signature]</i> <i>[Signature]</i>			
EL 2		3 PLACE DECIMALS ±		CHECKED <i>[Signature]</i> <i>[Signature]</i>			
RA		2 PLACE DECIMALS ±		ENGINEER <i>[Signature]</i>			
BH		MATERIAL		SUBMITTED <i>[Signature]</i>		SIZE CODE IDENT NO. DRAWING NO.	
RM		D8448501 M16		APPROVED <i>[Signature]</i>		C 19204 8448509	
		M16 A1				SCALE 2/1 SHEET OF	
		NEXT ASSY USED ON		FINAL PROTECTIVE FINISH			
		APPLICATION					

VIEW D
ALTERNATE METHOD

MAGNAFLUX TEST AND PROOF MARK SYMBOLS
.094 ±.015 HIGH, .005 MAX DEPTH IN
APPROX POSITION SHOWN (DO NOT STAMP)

—THESE NOTCHES RESULTANT
OF BROACHING METHOD

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING V61533 REV. E. WITH CHANGES	27 APR 70	
		A	(6) SEE EQ HRD 021452	10 JUL 70	
		B	(1) SEE EQ HRD 02197-3	15 SEP 70	
		C	(10) SEE EQ HQR-10634	20 FEB 71	
		D	(7) SEE FNR HQR 20778	5 OCT 72	
		E	NOR W523006 EQ-02-13	30 OCT 74	

MODIFIED SPECIFICATION
WHEN BROACHING METHOD
IS USED TO FORM LUGS

— MARK MFG IDENT SYMBOL .094±.015 HIGH,
.005 MAX DEPTH IN APPROX POSITION
SHOWN (DO NOT STAMP)

VIEW Y-Y
ROTATED 90° CW

SECTION U-U

109 REF (TO THEORETICAL
SHARP CORNER)
— .015 R -.005
14 PLACES

.102 ± .001
.051 DATUM

67° 30' BASIC

-.168±.002 FOR HALF DEPTH
REMAINING DEPTH MAY
VARY .005 DIA FROM 0

E	E
SH 2	SH 1

REVISION STATUS OF SHEETS

19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801
DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND

BOLT

SIZE	CODE IDENT NO	DRAWING NO
F	19204	8448510

CDI

5
4
3
2
1

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NOTE:

- STEEL, CORROSION-RESISTANT, PER MIL-S-5059. CMPSN 302 OR 304, CONDITION HARD, THICKNESS .016±.001.
- FINISH ¹²⁵✓ EXCEPT AS NOTED IN NOTE 4.
- EDGES TO BE SHARP TO .005 R MAX.
- MAX DIE BREAK ON -B- TO BE 50%. FINISH ON SHEARED SURFACE TO BE ⁶³✓.
- FINISH 5.4.1 OF MIL-STD-171.
- MIL-W-13855 APPLIES.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING	27 APR 70	
			C61540 REVISION B		
		A	(2) SEE ERR HQR 10852	24 SEP 71	JB
		B	(2) SEE ERR HQR 20778	6 OCT 72	RC
		C	NOR W9S2009 80-02-13	80-05-16	ARW

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	
RH	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES:

ANGLES: —

3 PLACE DECIMALS: ± .01

2 PLACE DECIMALS: ± .01

MATERIAL: SEE NOTE 1

FINAL PROTECTIVE FINISH: SEE NOTE 5

CONTRACT NO. DATE 27 APR 1970

PREP: *PAH*

CHK: *PAH*

ENGR: *PAH*

SUBMITTED: *7. P. Wilhooy*

APPROVED: *R. B. Henry*

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19200

SIZE B CODE IDENT NO. 19204 DRAWING NO. 8448511

SCALE 5 / 1 SHEET 1 OF 1

MECHANICAL PROPERTIES

YS MIN

YS MAX

EL 2

RA

BH

RH

C9327073 M231

C8448509 M16A1

APPLICATION

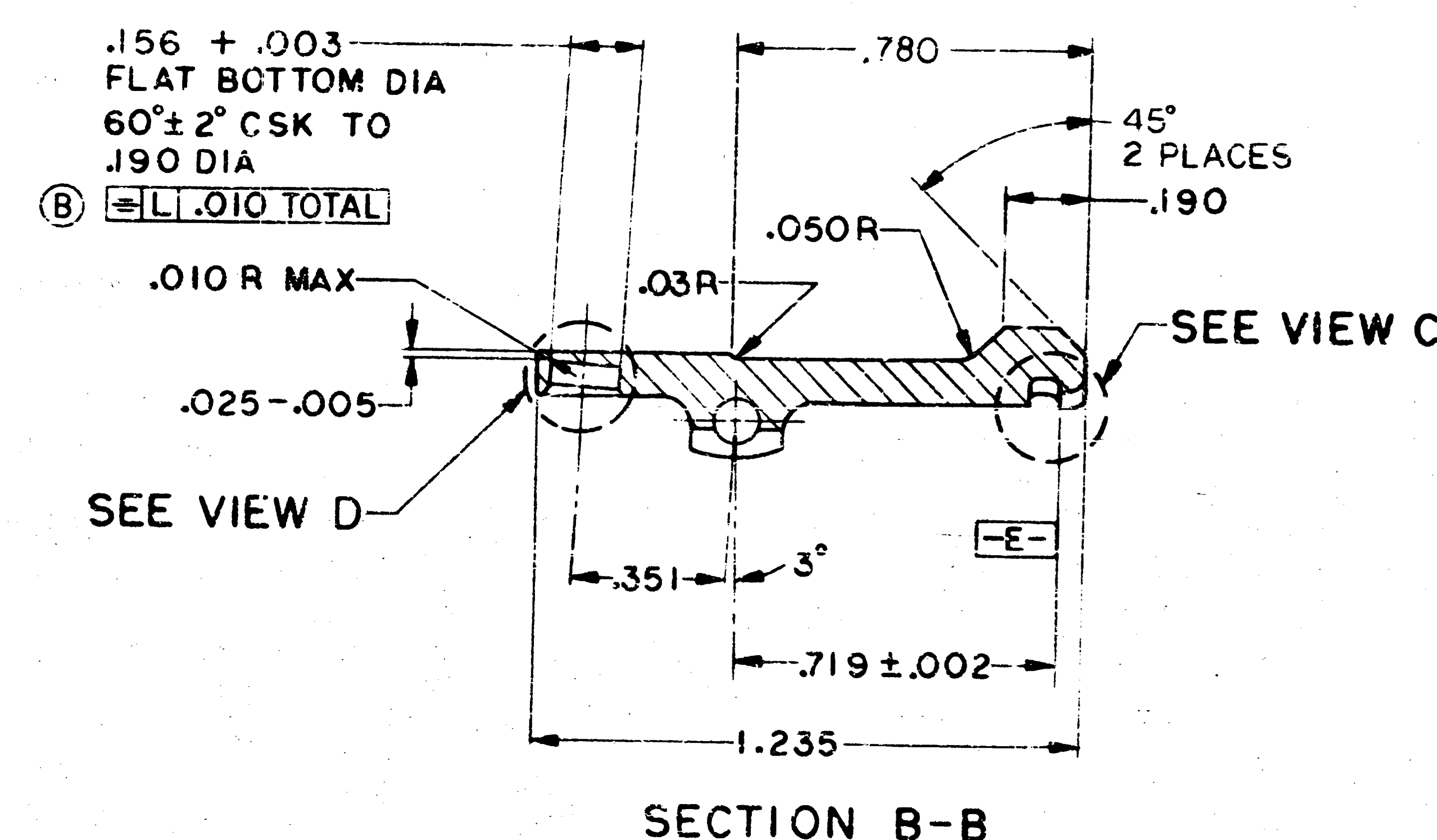
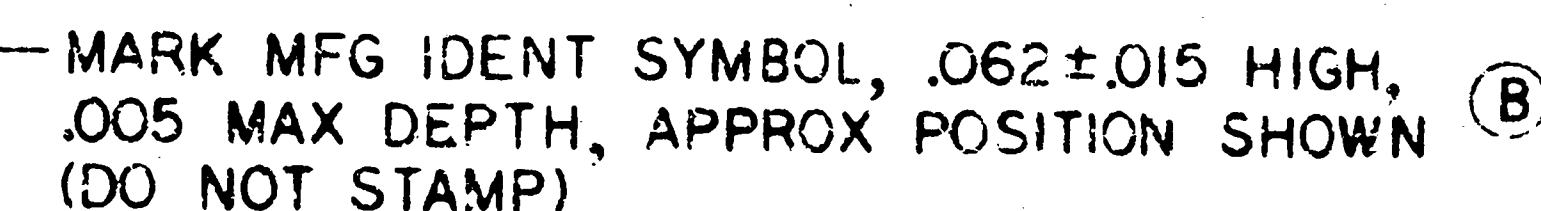
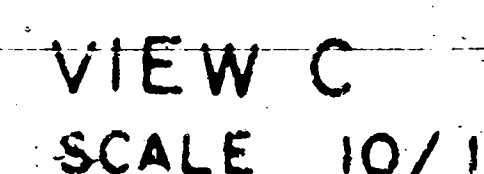
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1. STEEL, AISI 4140 OR AISI 4340, GUN QUALITY, (A)
ANNEALED, COLD DRAWN
AND STRESS RELIEVED BHN 187/229.

3. AUSTEMPER SUGGESTED
PROCEDURE: HEAT TO 1550°F
IN NEUTRAL SALT BATH.
TRANSFER TO 680°F SALT
BATH. HOLD 20 TO 25 MIN.
AIR COOL.

5. BREAK SHARP EDGES .005+.010 (A)
UNLESS OTHERWISE SPECIFIED.

7. MIL-W-13955 APPLIES.



REVISONS			DATE	APPROVED
NO	ZONE	LIT	DESCRIPTION	
			REDRAWN FROM C.D.'S DRAWING	
			J61562 REVISION D	27APR 70
6		A	(2) SEE EO HRO 02197-3	15 JUL 70
7		B	(9) SEE ERR HQR 20778	6 OCT 72
8		C	INOP W952009	80 05 16
9		D	INOP W550001/85 01-14	950716
10		E	INOP W550025 86-07-21	870216
11		F	INCR W6500271 86-06-06	

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES ANGLES ± 1° 3 PLACE DECIMALS .005 2 PLACE DECIMALS .01		CONTRACT NO.		DRAWING NO.	
15 MIN		MATERIAL		DATE 27 APR 1970		DOVER, NEW JERSEY 08041	
15 MAX		SEE NOTE 1		PREPARED BY <i>W. H. Smith</i>		DEPT OF THE ARMY	
FL2	C53/9703 M23			CHECKED BY <i>C. J. Smith</i>		US ARMY RESEARCH COMMAND	
EA				DESIGNED BY <i>W. H. Smith</i>		ROCK ISLAND, ILLINOIS 61201	
BN	MIC			SUBMITTED BY <i>W. H. Smith</i>		EXTRACTOR	
BN C42-44	C8448509 MISA1			APPROVED BY <i>W. H. Smith</i>		157	
	NEXT ASSY. USED ON	FINAL PROJECTIVE TEST		F 19204		8448512	
	APPLICATION	5.3.2 OF MIL-STD-171		SCALE 1/1		SHEET 1	

5		4		3		2		1																																																																																																	
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		B	NOR W9S2009 80-02-13	80-05-16	MR. RIA																																																																																																				
<p>NOTE:</p> <ol style="list-style-type: none"> 1. FINISH I25/ EXCEPT AS NOTED. 2. OIL QUENCH FROM 1600°F, TEMPER AT 275°F TO 400°F. (A) 3. AFTER TEMPERING, STEEL SHOT PEEN ALL OVER. S-70 SHOT, .005+.002-A2 ALMEN, 150% COVERAGE. 4. CLEAN IN ACCORDANCE WITH TT-C-490, METHOD III OR IV. FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT OMIT SANDBLAST. 5. MIL-W-13855 APPLIES. (A) 					<p style="text-align: center;">.020 2 PLACES</p> <p style="text-align: center;">.442</p> <p style="text-align: center;">33° CHAMFER 2 PLACES</p> <p style="text-align: center;">.1000 DIA ± .0003 DIAMETER AFTER FINISH .1001 ± .0010</p>																																																																																																				
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AMSWE Form 403B, 29 Jul 69

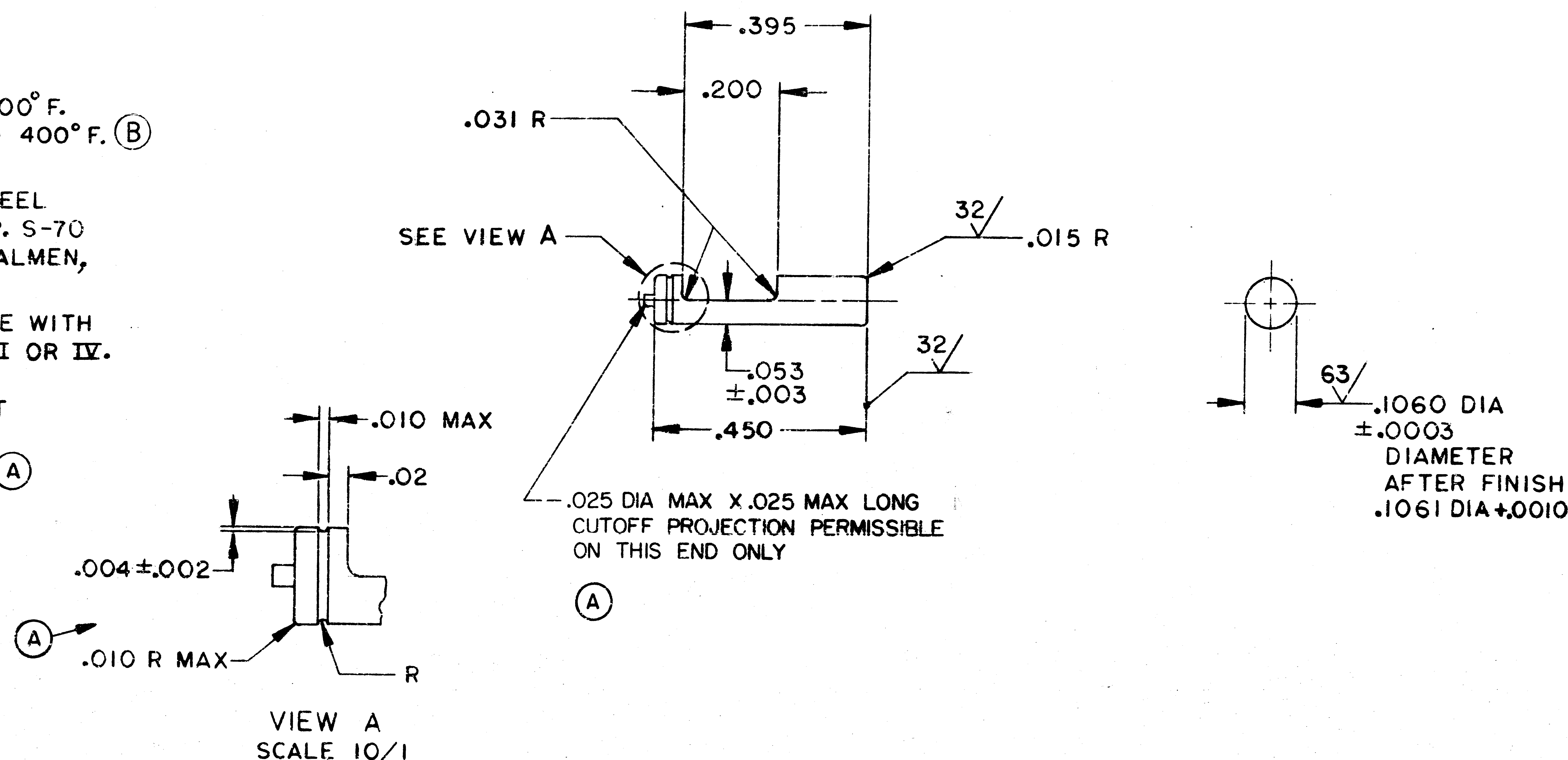
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B8448513

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REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
1			REDRAWN FROM COLT'S DRAWING	27 APR 70	
			CS1564 REVISION B		
		A	(3)SEE EO HRD 02255	15 OCT 70	F.P. Miller
		B	(2)SEE ERR HQR 20778	6 OCT 72	Joe
		C	NOR W952009	20-02-13	20-05-16

- NOTE: 1. FINISH $\sqrt{125}$ EXCEPT AS NOTED.
2. BREAK SHARP EDGES .010 R MAX.
3. OIL QUENCH FROM 1600° F. TEMPER AT 275° F TO 400° F. (B)
4. AFTER TEMPERING, STEEL SHOT PEEN ALL OVER. S-70 SHOT, .005-.007-A2 ALMEN, 150 % COVERAGE.
5. CLEAN IN ACCORDANCE WITH TT-C-490, METHOD III OR IV. FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT OMIT SANDBLAST.
6. MIL-W-13855 APPLIES. (A)



CODE IDENT NO
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

~~DEPT OF THE ARMY~~
~~U.S. ARMY WEAPONS COMMAND~~
~~ROCK ISLAND, ILLINOIS, 61201~~

EJECTOR

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DOVER, NEW JERSEY 07801	
YS MIN				TOLERANCES:				DEPT OF THE ARMY	
YS MAX				ANGLES \pm				U.S. ARMY WEAPONS COMMAND	
EL 2				3 PLACE DECIMALS \pm .005				ROCK ISLAND, ILLINOIS, 61201	
RA				2 PLACE DECIMALS \pm .01					
BH				MATERIAL		DATE 27 APR 1970			
RM	15N 88.5 -90.5	C9327073	M231	TOOL STEEL, CLASS S2.		PREPARED <i>R617</i>		EJECTOR	
			M16	SPEC QQ-T-570		CHECKED <i>[Signature]</i>			
		C8448509	MIGAL			ENGINEER <i>[Signature]</i>			
		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH		SUBMITTED <i>[Signature]</i>		SIZE CODE IDENT NO DRAWING NO.	
APPLICATION				SEE NOTE 5		APPROVED <i>[Signature]</i>		C 1000 8448515	
								SCALE 5/1 SHEET OF	

5

4

3

2

1

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REVISIONS			
MF	ZONE	LTR	DESCRIPTION
		C	REPLACES REV B W/CHANGE SEE ERR HQR 20778
		D	NOR W952009 80-02-13
		E	NOR W2S 0011 / 82-04-13 (ECP W3S 3120 / 83-07-07)

6 OCT 72

Z B

80-05-16

J. R. R. R.

83-11-04

J. R. R. R.

SPRING, HELICAL, COMPRESSION

NOTES:

1. WIRE, STEEL, CARBON, SPRING, MUSIC, SPEC QQ-W-470. TENSILE STRENGTH SHALL BE 376,000 MIN.
2. STRESS RELIEVE AFTER FORMING. HOLD AT 475°F ± 25° FOR 30 MINUTES.
3. SET SPRING 3 TIMES AFTER STRESS RELIEF.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003 ± .012.

WIRE DIAMETER _____ .0240 ± .0003
 COIL DIAMETER (O.D.) _____ .103 ± .003
 FREE LENGTH AFTER SETTING _____ 926 REF
 TOTAL COILS _____ 27 REF
 DIRECTION OF HELIX _____ OPTIONAL
 LOAD AT COMPRESSED LENGTH OF .850 _____ 2.94 LB ± .30 LB
 LOAD AT COMPRESSED LENGTH OF .784 _____ 5.50 LB ± .25 LB
 SPRING RATE _____
 SOLID LENGTH _____ 650 MAX
 TYPE OF ENDS _____ SQUARED, GROUND
 MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572

FSCM NO.
19200

CURRENT

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448516

MECHANICAL PROPERTIES		F9327230 M 231		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY.	
YS	MIN			TOLERANCES:	DATE 27 APR 70	U.S. ARMY WEAPONS COMMAND			
YS	MAX			ANGLES ±	PREP P. Vernon	ROCK ISLAND, ILLINOIS, 61201			
EL 2				3 PLACE DECIMALS ± .005	CHK P. Vernon	SPRING, EJECTOR AND			
RA				2 PLACE DECIMALS ±	ENGR P. Elbe	SAFETY DETENT			
BH				MATERIAL	SUBMITTED	SIZE CODE IDENT NO DRAWING NO.			
RH				SEE NOTE 1	APPROVED	B 19204 8448516			
		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH		SCALE NONE SHEET 1 OF 1			
		APPLICATION							

AMSWE Form 403B, 29 Jul 69

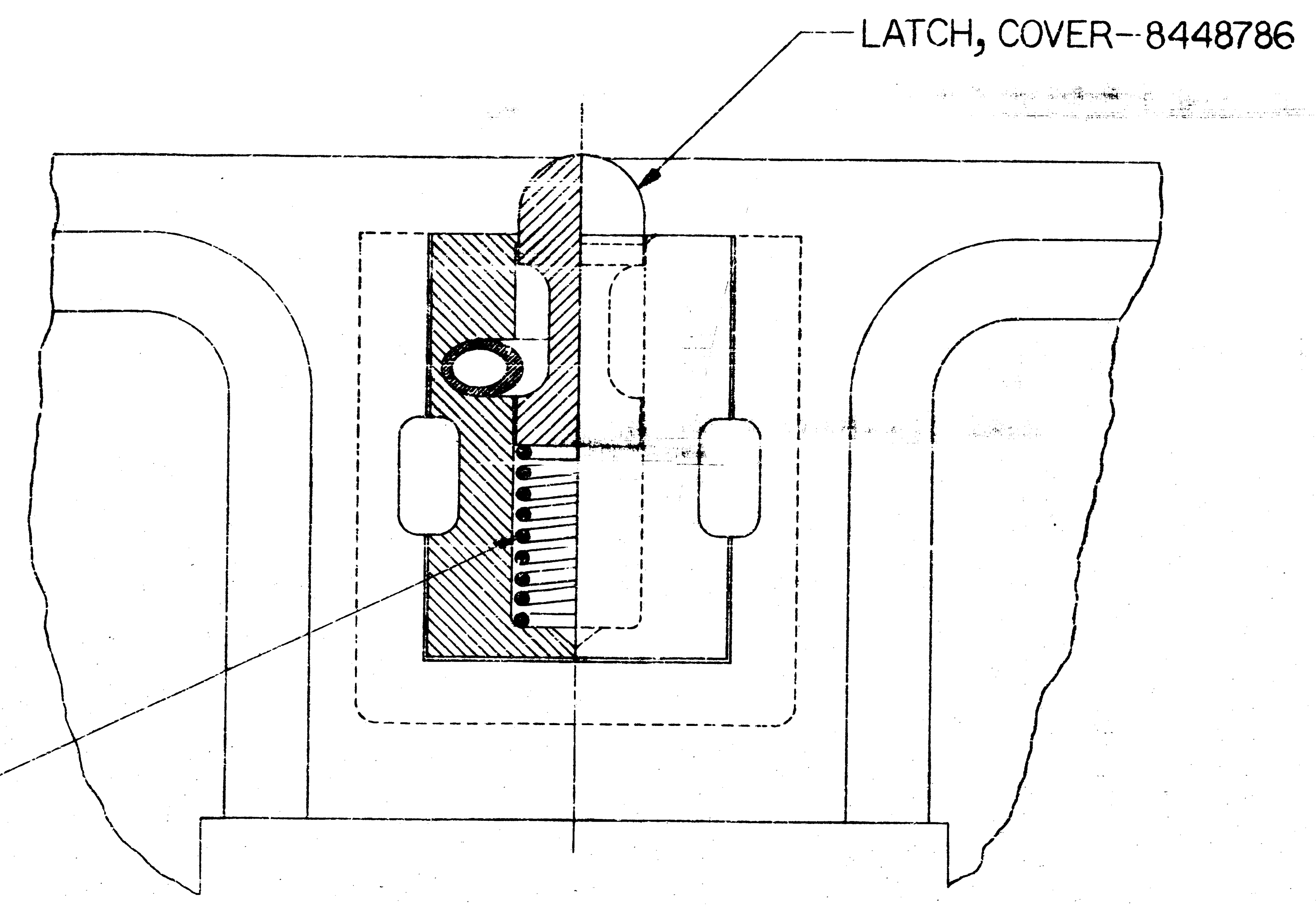
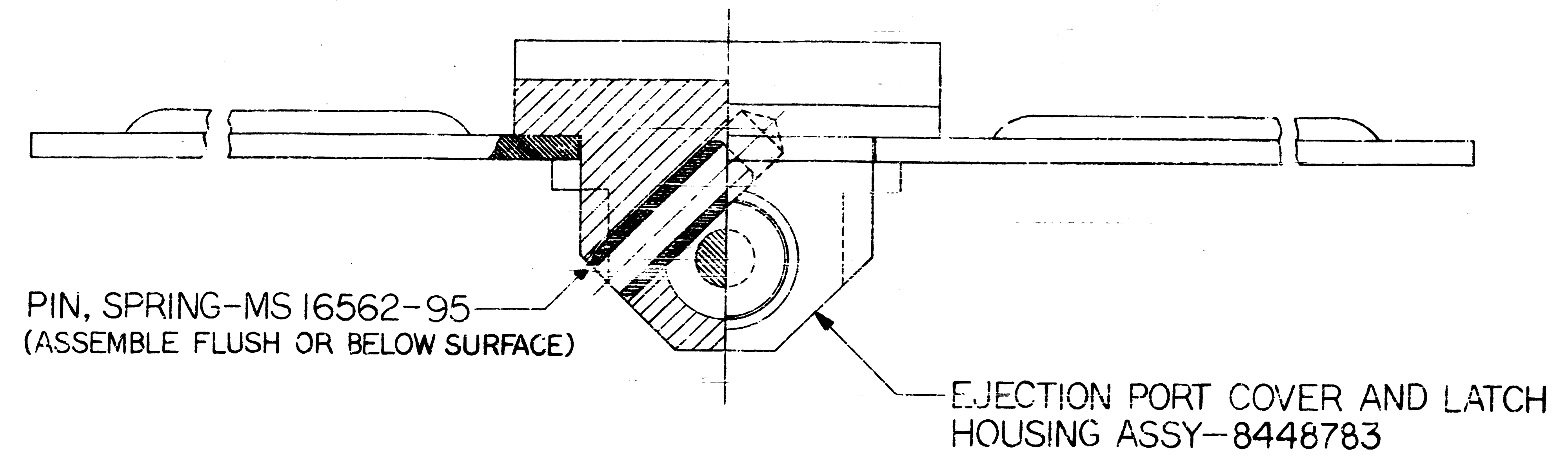
8448516

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REVISIONS				
MP	ZONE	LTR	DESCRIPTION	DATE
M		A	REPLACES REV (-) W/CHANGE SEE FRR HQR 20/43	21 SEPT 72
		B	NOR W952009 80-02-13	80-05-16

- NOTES:
1. THE LOAD NECESSARY TO DEPRESS THE LATCH, COVER 8448786, .060 INCHES FROM ITS ASSEMBLED POSITION SHALL BE $1.2 \pm .3$ LB.
 2. MIL-W-13855 APPLIES.



SPRING, COVER LATCH-8448787

SEE PL-8448525		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		PART NO. 8448525		CODE IDENT NO. 19200	
MECHANICAL PROPERTIES		TOLERANCES		DATE 27 APR 70		EJECTION PORT COVER ASSY		A	
YS		ANGLES		PREPARED <i>[Signature]</i>		EJECTION PORT COVER ASSY			
MIN		3 PLACE DECIMALS		CHECKED <i>[Signature]</i>		EJECTION PORT COVER ASSY			
YS		2 PLACE DECIMALS		ENGINEER <i>[Signature]</i>		EJECTION PORT COVER ASSY			
MAX		MATERIAL		SUBMITTED <i>[Signature]</i>		EJECTION PORT COVER ASSY			
EL 2		D9327228 M 231		APPROVED <i>[Signature]</i>		EJECTION PORT COVER ASSY			
RA		D8448602 M16		SCALE 10/1		EJECTION PORT COVER ASSY			
BM		D8448523 M16A1		SHEET 1 OF 1		EJECTION PORT COVER ASSY			
KH		NEXT ASSY USED ON		EDITION OF 29 JUL 69 MAY BE USED		EJECTION PORT COVER ASSY			
APPLICATION		FINAL PROTECTIVE FINISH				EJECTION PORT COVER ASSY			

4 3 2 1

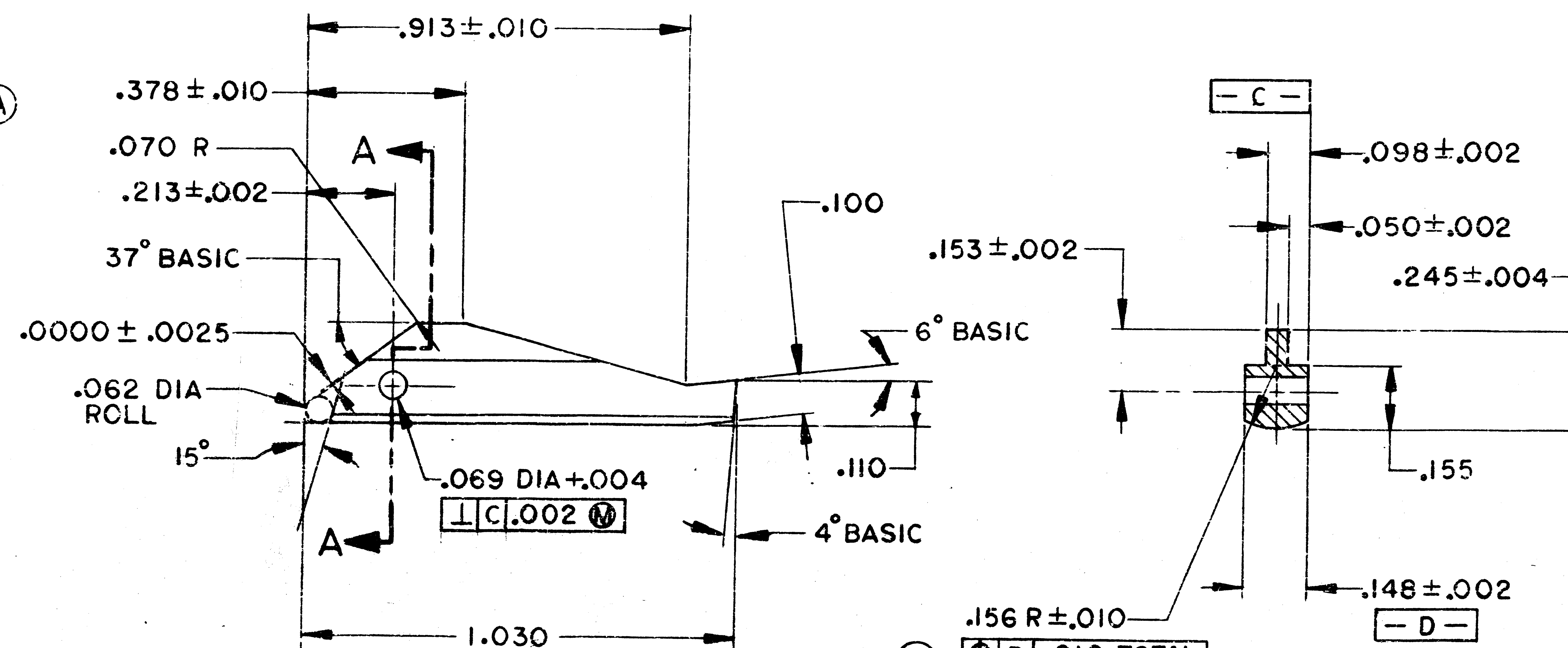
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REVISIONS				
REV	ZONE	LTR	DESCRIPTION	DATE
1			REDRAWN FROM COLT'S DRAWING	27 APR 70
2			C62269 REVISION B	
3	A		(3) SEE ERR HQR 20778	6 OCT 72
4	B		NOR W9S2009	80-02-13
				80-05-16

NOTE:-

1. FINISH 63/
2. BREAK ALL EDGES .005+.005.
3. STEEL, CMPSN 1137, 1141, OR 1144, SPEC ASTM A322 OR ASTM A331.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES.



SECTION A-A

CODE IDENT NO.
19200

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
YS MIN		TOLERANCES	
YS MAX		ANGLES ± 1°	
EL 2		3 PLACE DECIMALS ± .005	
RA		2 PLACE DECIMALS ± .005	
BH		MATERIAL	
RH	C44-48	SEE NOTE 3	
		FINAL PROTECTIVE FINISH	
		5.3.1.2. OF	
		MIL-STD-171	

CONTRACT NO.

DATE 27 APR 1970

PREPARED RGA

CHECKED RGA

ENGINEER RGA

SUBMITTED T.P. Gellor

APPROVED K.S. Henry

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

PAWL,
FORWARD ASSIST

SIZE	CODE IDENT NO.	DRAWING NO.
C	19200	8448543

8 7 6 5 4 3 2 1

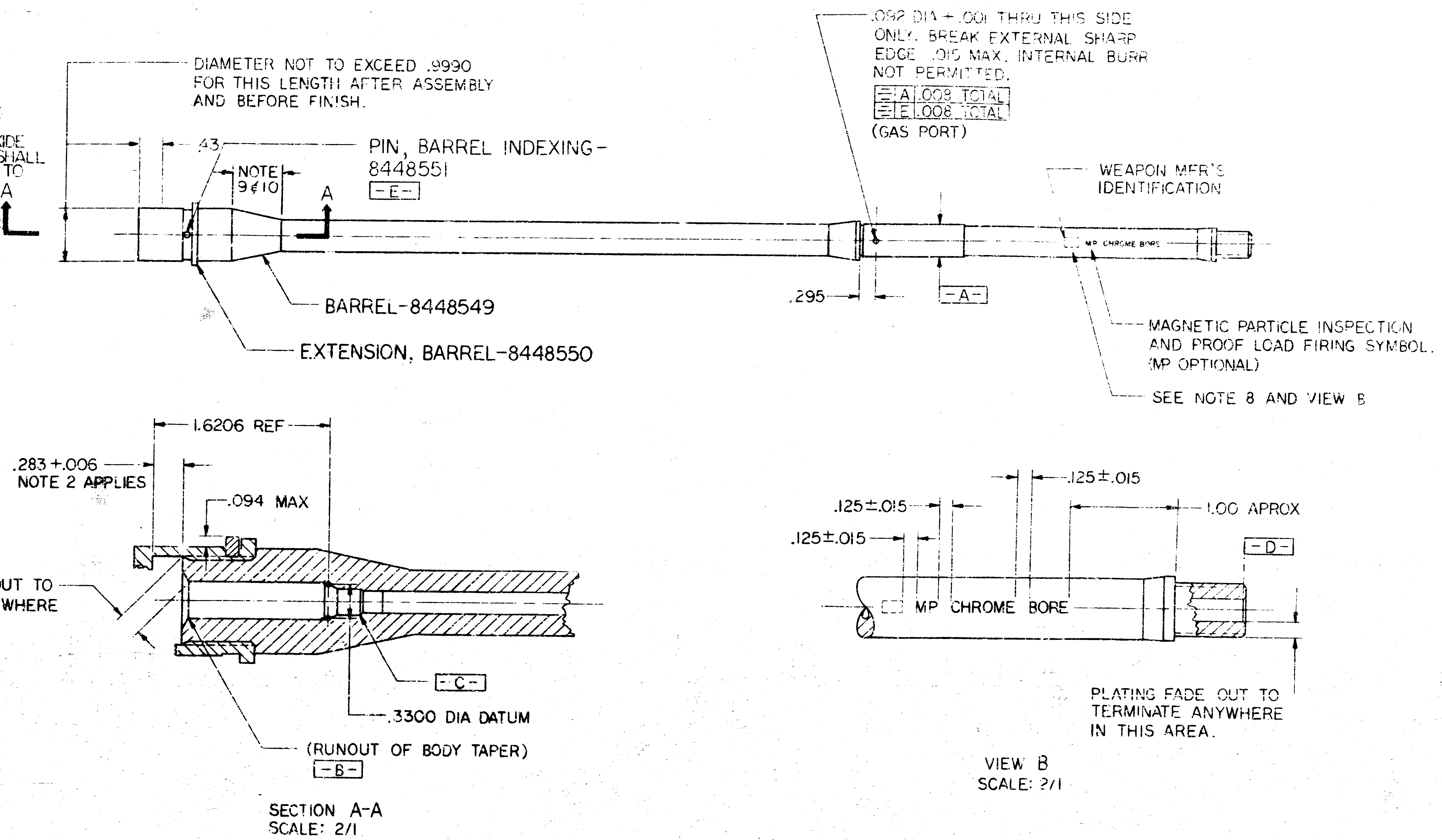
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REVISIONS			
NO.	DATE	DESCRIPTION	APPROVED
1	1970	REVISED TO SHOW W/CHANGES	
2	1970	REVISED TO SHOW W/CHANGES	
3	1970	REVISED TO SHOW W/CHANGES	
4	1970	REVISED TO SHOW W/CHANGES	
5	1970	REVISED TO SHOW W/CHANGES	
6	1970	REVISED TO SHOW W/CHANGES	
7	1970	REVISED TO SHOW W/CHANGES	
8	1970	REVISED TO SHOW W/CHANGES	
9	1970	REVISED TO SHOW W/CHANGES	
10	1970	REVISED TO SHOW W/CHANGES	

- NOTES:
- FOR FINISHED CHAMBER DIMENSIONS AFTER PLATING SEE DWG 8448549 AND SECTION A-A. FOR FINISHED BORE DIMENSIONS AFTER PLATING SEE DWG 8448550.
 - TORQUE BARREL AND BARREL EXTENSION TO 150 LB FT ± 5 LB FT. .283 DIMENSION APPLIES AFTER TORQUING TO REQUIRED LOAD.
 - FINISH REAM CHAMBER AFTER ASSEMBLY.
 - PROTECTIVE FINISH:
 - INTERIOR: CHROMIUM PLATE CHAMBER AND BORE FINISH 12.22 OF MIL-STD-171. FILM THICKNESS BETWEEN POINTS C AND D .003 TO .005. FILM THICKNESS BETWEEN POINTS A AND B .004 TO .005.
 - CHROMIUM PLATING SHALL NOT HAVE A CONCENTRATION OF CHROMIUM THIOXIDE (CHROMIUM TRIOXIDE) PER CALON CHROMIC ACID TO SULPHATE RATIO SHALL BE 84 TO 96. THE OPERATING TEMPERATURE SHALL BE MAINTAINED AT 150° TO 160° F. THE CURRENT DENSITY SHALL BE MAINTAINED 5. THE DEPOSIT IS ESSENTIALLY OF A DENSE, CRACK-FREE CHARACTER WHEN VIEWED UNDER 100X MAGNIFICATION.
 - EXTERIOR: 5.3.1.2 OF MIL-STD-171.
 - AFTER CHROME PLATING CHAMBER AND BORE, EACH BARREL ASSEMBLY SHALL WITHSTAND THE FIRING OF ONE HIGH PRESSURE TEST CARTRIDGE M197, WITHOUT EVIDENCE OF FAILURE.
 - AFTER PROOF FIRING, EACH BARREL ASSEMBLY SHALL BE MAGNETIC PARTICLE INSPECTED FOR CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS USING A CURRENT OF 400 TO 500 AMPERES FOR CIRCULAR CONTINUOUS MAGNETIZATION.
 - AFTER PROOF FIRING AND MAGNETIC PARTICLE INSPECTION, GRIT BLAST EXTERIOR PRIOR TO FINAL PROTECTIVE FINISH, TO PRODUCE NONREFLECTIVE MATTE FINISH. MASK CHAMBER, FEED CONE, BORE AND CROWN (MUZZLE END).
 - AFTER PROOF LOAD FIRING AND MAGNETIC PARTICLE INSPECTION EACH BARREL SHALL BE MARKED AS FOLLOWS:

MFG IDENT, MAGNETIC PARTICLE INSPECTION / PROOF LOAD FIRING SYMBOL, AND "CHROME BORE" SHALL BE .094 \pm .015 HIGH IN AREA SHOWN VISUALLY IN LINE WITH THE .092 DIA GAS PORT.
 - ABOVE MARKINGS SHALL BE LEGIBLE AND PERMANENT SO AS TO BE CAPABLE OF WITHSTANDING THE ENVIRONMENTAL AND CLEANING REQUIREMENTS FOR THE ASSEMBLY.
 - SINGLE LETTER CHROME PLATE VENDOR IDENT. PERMISSIBLE THIS AREA ONLY.
 - MIL-W-13855 APPLIES.



SEE PL-8448548

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 27 APR 70	
Y	MIN	TOLERANCES ON	DECIMALS	REVISED	BY
1	MAX	ANGLES	1/16, 1/8, 1/4, 1/2, 1	1	1
2	MIN	MATERIAL	SEE NOTE 4	2	2
3	MAX	HEAT TREATMENT	SEE NOTE 5	3	3
4	MIN	FINISH	SEE NOTE 6	4	4
5	MAX	TEST METHOD	SEE NOTE 7	5	5
6	MIN	APPLICATION	SEE NOTE 8	6	6

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER, ROCK ISLAND, ILL. 61201

PART NO 8448548

DEPT OF THE ARMY

ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201

BARREL AND BARREL EXTENSION ASSEMBLY

DWG SIZE CODE IDENT NO 19204 8448548

SCALE 1:1

REVISIONS		DATE	APPROVED
MR	DESCRIPTION		
D	REPLACES REV. WITH RANGE	14 APR 72	
E	SEE ERR NGR 20027		
F	SEE ERR NGR 30545	2 MAR 73	RL
G	SEE NGR 770005-0000	2E APR 77	JP
H	NOR 6753121 / 676923	680926	

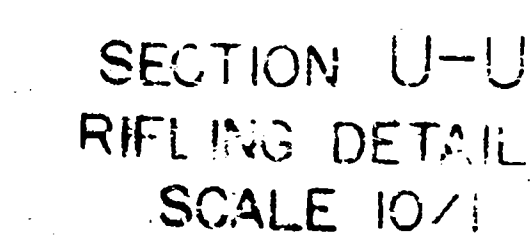
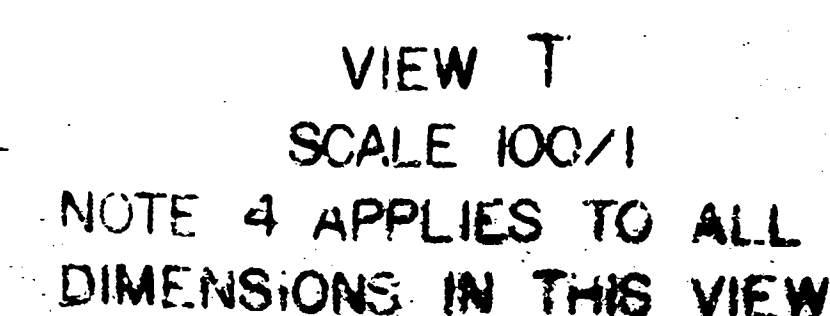
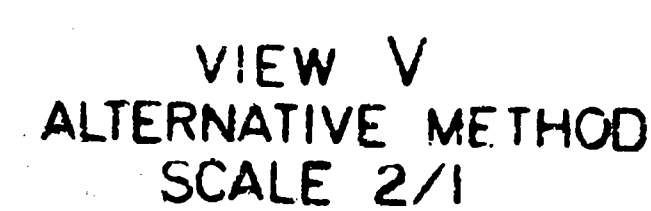
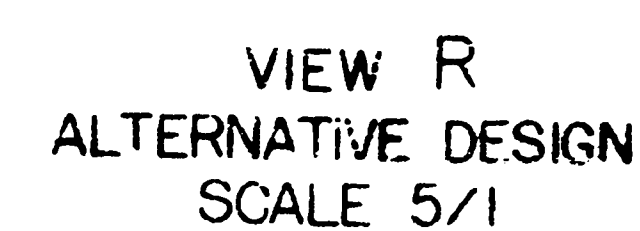
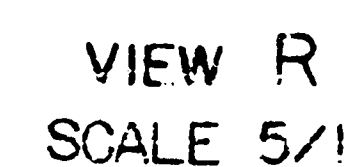
-
- MANUFACTURING IN-PROCESS CONTROL MARK PERMISSIBLE THIS SURFACE, RANDOM RADIAL ORIENTATION. MARKS SHALL BE .094 MAX HIGH, .005 MAX DEPTH, AND SHALL NOT DUPLICATE OTHER BARREL MARKINGS.
- 19.834 ± .015
- 2.130 ± .020
- 1.256 ± .030
- .620 ± .001
- .045 × 45° CHAM
- .19 R
- 250/
- 20° 8' INCL REF
- .67 DIA
- .19 R
- .75 DIA
- .60 DIA
- 1.890 ± .020
- .095 ± .015
- 32/
- .04 R
- .57 DIA
- .6238 DIA ± .0005
- .095 ± .015
- .63
- 250/
- 16°
- .04 R
- .61 DIA
- .9800 ± .0005 ANGULAR DEVIATION CONTROL DIAMETER
- 1.0015
- 1.0015
- 12.125
- SEE VIEW V
- 12 × .730 DIA - .005 THREAD RELIEF
- .010 R
- 45° ± 2°
- FOR CHAMBER SEE DWG 8448548
- .031 R
- 1.812 BASIC
- 16 UN - 3A MOD
- MAJOR DIA .8080 / .8000 MOD
- ITCH DIA .7719 / .7683
- NOR DIA .7358 MAX
- 1/2 - 28 UNEF -
- MAJOR DIA .45
- PITCH DIA .47
- MINOR DIA .43
- SEE VIEW S
- SEE VIEW R
- .032 ± .007 × 45° CHAMFER
- SECTION M-M

[illegible]

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT DOVER NEW JERSEY 07801			
PART NO. 8448549			
DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201			
BARREL			
F	19204	8448549	

THIS DOCUMENT CONTAINS INFORMATION RELATING TO THE PREPARATION OF THIS REPORT AND THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS THE POLICY OF THE UNITED STATES GOVERNMENT TO MAKE ALL INFORMATION CONTAINED HEREIN AVAILABLE TO THE PUBLIC UNLESS IT IS DETERMINED THAT DISCLOSURE OF THE INFORMATION WOULD BE DETERMINED TO BE IN THE INTERESTS OF NATIONAL DEFENSE. IF YOU ARE A CONTRACTOR OF THE UNITED STATES GOVERNMENT, YOU ARE ADVISED THAT IT IS YOUR POLICY TO MAKE ALL INFORMATION CONTAINED HEREIN AVAILABLE TO THE PUBLIC UNLESS IT IS DETERMINED THAT DISCLOSURE OF THE INFORMATION WOULD BE DETERMINED TO BE IN THE INTERESTS OF NATIONAL DEFENSE. IF YOU ARE A CONTRACTOR OF THE UNITED STATES GOVERNMENT, YOU ARE ADVISED THAT IT IS YOUR POLICY TO MAKE ALL INFORMATION CONTAINED HEREIN AVAILABLE TO THE PUBLIC UNLESS IT IS DETERMINED THAT DISCLOSURE OF THE INFORMATION WOULD BE DETERMINED TO BE IN THE INTERESTS OF NATIONAL DEFENSE.

REVISIONS				
NO.	ZONE	DESCRIPTION	DATE	BY
	D	REPLACES REV C W/CHANGE SEE ERR HGR 20827	14 DEC 72	W
	E	121 SEE ERR HGR 20645	2 MAR 73	W
	F	121 SEE NOR 77E0005-0000	26 JUN 77	W
	G	NOV 63 2002E @ 05:21	83 OCT 68	W
	H	NOV 4753121 / 8709281	89 DEC 68	W



MECHANICAL PROPERTIES		TENSILE STRENGTH TESTED (TENSILE STRENGTH IN TENSILE) STRESS IN PSI 37,400 STRESS IN PSI 37,400 STRESS IN PSI 37,400 STRESS IN PSI		PART NO. 8448549 DEPT OF THE ARMY US ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, SIGO	
5		DATE: 27 APR 70 PREPARED BY: [Signature] CHECKED BY: [Signature] APPROVED BY: [Signature]		BARREI	
5		NEXT ASSY USED ON APPLICATION		F 19204 8448549	

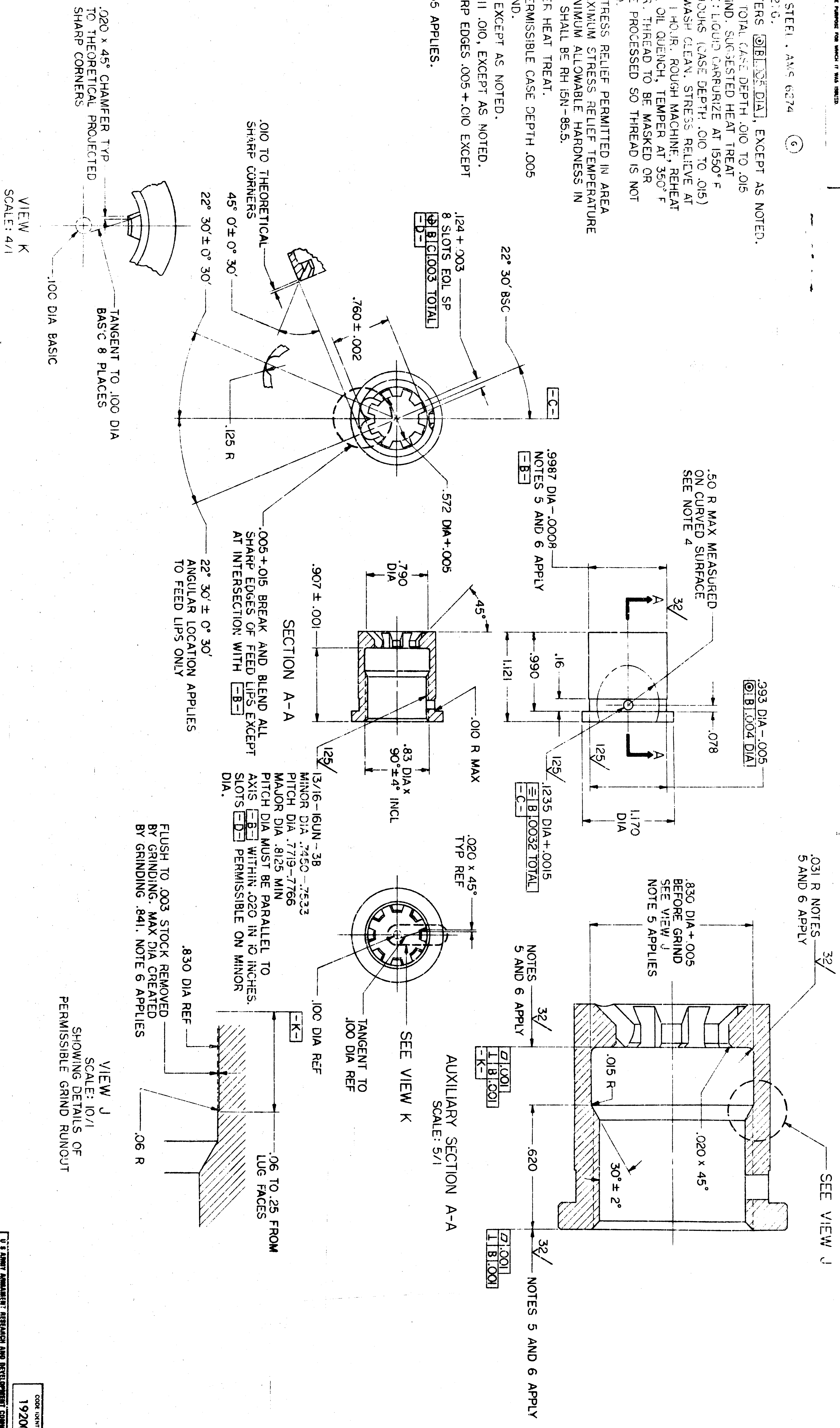
EDITION OF 29 JUL 70 MAY BE USED

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REVISIONS			
NO.	DATE	DESCRIPTION	APPROVED
1	27 APR 70	EXTENSION, BARREL	
2	10 MAY 70	REPLACES REV. 1 W/CHANGE	
3	10 MAY 70	SEE REV. 10/1	
4	10 MAY 70	SEE REV. 10/1	
5	10 MAY 70	SEE REV. 10/1	
6	10 MAY 70	SEE REV. 10/1	
7	10 MAY 70	SEE REV. 10/1	
8	10 MAY 70	SEE REV. 10/1	
9	10 MAY 70	SEE REV. 10/1	
10	10 MAY 70	SEE REV. 10/1	

NOTES:

1. SAE 8620 STEEL, AMS 6274 (6)
2. OR AMS 4215.
3. ALL DIAMETERS $\pm .005$ DIA, EXCEPT AS NOTED.
4. CARBURIZE TOTAL CASE DEPTH .010 TO .015 BEFORE GRIND. SUGGESTED HEAT TREAT PROCEDURE: LIQUID CARBURIZE AT 1550° F FOR 1 1/2 HOURS (CASE DEPTH .010 TO .015) AIR COOL, WASH CLEAN, STRESS RELIEVE AT 850° F FOR 1 HOUR, ROUGH MACHINE, REHEAT TO 1450° F, OIL QUENCH, TEMPER AT 350° F FOR 1 HOUR. THREAD TO BE MASKED OR PART TO BE PROCESSED SO THREAD IS NOT CARBURIZED.
5. OPTIONAL STRESS RELIEF PERMITTED IN AREA SHOWN. MAXIMUM STRESS RELIEF TEMPERATURE 900° F. MINIMUM ALLOWABLE HARDNESS IN THIS AREA SHALL BE RH 15N-85.5.
6. GRIND AFTER HEAT TREAT.
7. MINIMUM PERMISSIBLE CASE DEPTH .005 AFTER GRIND.
8. FINISH $\pm .005$ EXCEPT AS NOTED.
9. BREAK SHARP EDGES .005 + .010 EXCEPT AS NOTED.
10. MIL-W-13855 APPLIES.



REVISIONS			
NO.	DATE	DESCRIPTION	APPROVED
1	27 APR 70	EXTENSION, BARREL	
2	10 MAY 70	REPLACES REV. 1 W/CHANGE	
3	10 MAY 70	SEE REV. 10/1	
4	10 MAY 70	SEE REV. 10/1	
5	10 MAY 70	SEE REV. 10/1	
6	10 MAY 70	SEE REV. 10/1	
7	10 MAY 70	SEE REV. 10/1	
8	10 MAY 70	SEE REV. 10/1	
9	10 MAY 70	SEE REV. 10/1	
10	10 MAY 70	SEE REV. 10/1	

DESIGNER	DATE	APPROVED
W. J. H. H.	27 APR 70	
W. J. H. H.	10 MAY 70	
W. J. H. H.	10 MAY 70	
W. J. H. H.	10 MAY 70	
W. J. H. H.	10 MAY 70	
W. J. H. H.	10 MAY 70	
W. J. H. H.	10 MAY 70	
W. J. H. H.	10 MAY 70	
W. J. H. H.	10 MAY 70	
W. J. H. H.	10 MAY 70	

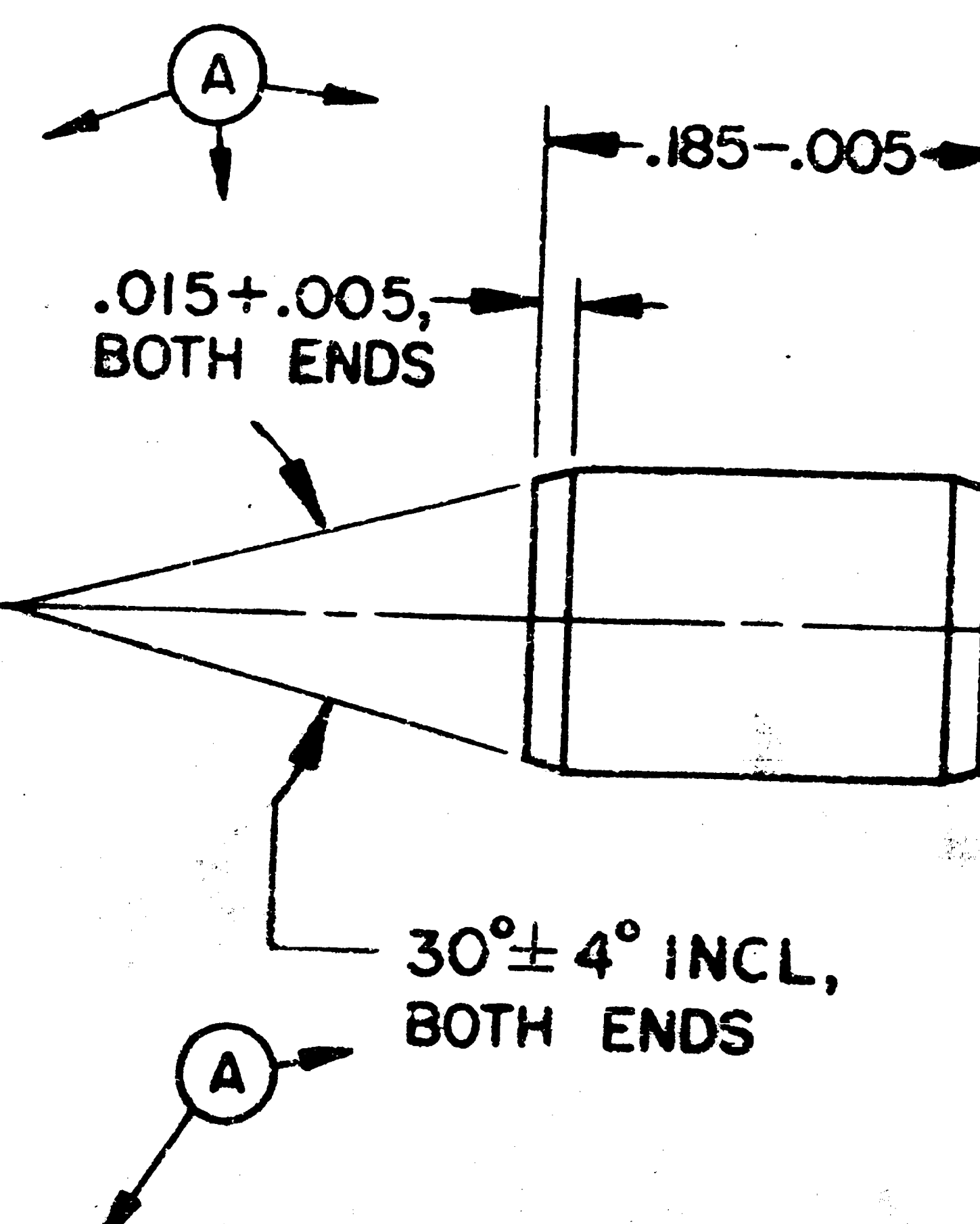
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A B C D E F G H

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NOTES:

1. FINISH $125\sqrt{\text{EXCEPT AS NOTED.}}$
2. BREAK SHARP EDGES .010 MAX.
3. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. (B)
4. STEEL CARBON, CMPSN 1137, 11L37 OR 1141, 11L41, SPEC ASTM A108-81.
5. MIL-W-13855 APPLIES.



REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
			REDRAWN FROM COLT'S DRAWING	
			B61671 REVISION B	27 APR 70
		A	(2) SEE ERR HQR 10906	15 DEC 71
		B	(4) SEE ERR HQR 20827	14 DEC 72
		C	NOR W9S2009 80-02-13	80-05-16
		D	NOR W3S3133/83-08-25	83-11-04

CURRENT

FSCM NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

PIN, BARREL INDEXING

SIZE CODE IDENT NO. DRAWING NO.
B 19204 8448551

SCALE 10/1 SHEET OF

CDI

MECHANICAL PROPERTIES			
YS MIN			
YS MAX			
EL 2			
RA			
BH			
RH	15N 785-80.5		

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES:
3 PLACE DECIMALS ±
2 PLACE DECIMALS ±
MATERIAL

SEE NOTE 4

FINAL PROTECTIVE FINISH

CONTRACT NO.	
DATE	27 APR 1970
PREP	RGB AG-A
CHK	AG-A
ENGR	AG-A
SUBMITTED	AG-A
APPROVED	R.D. Henry

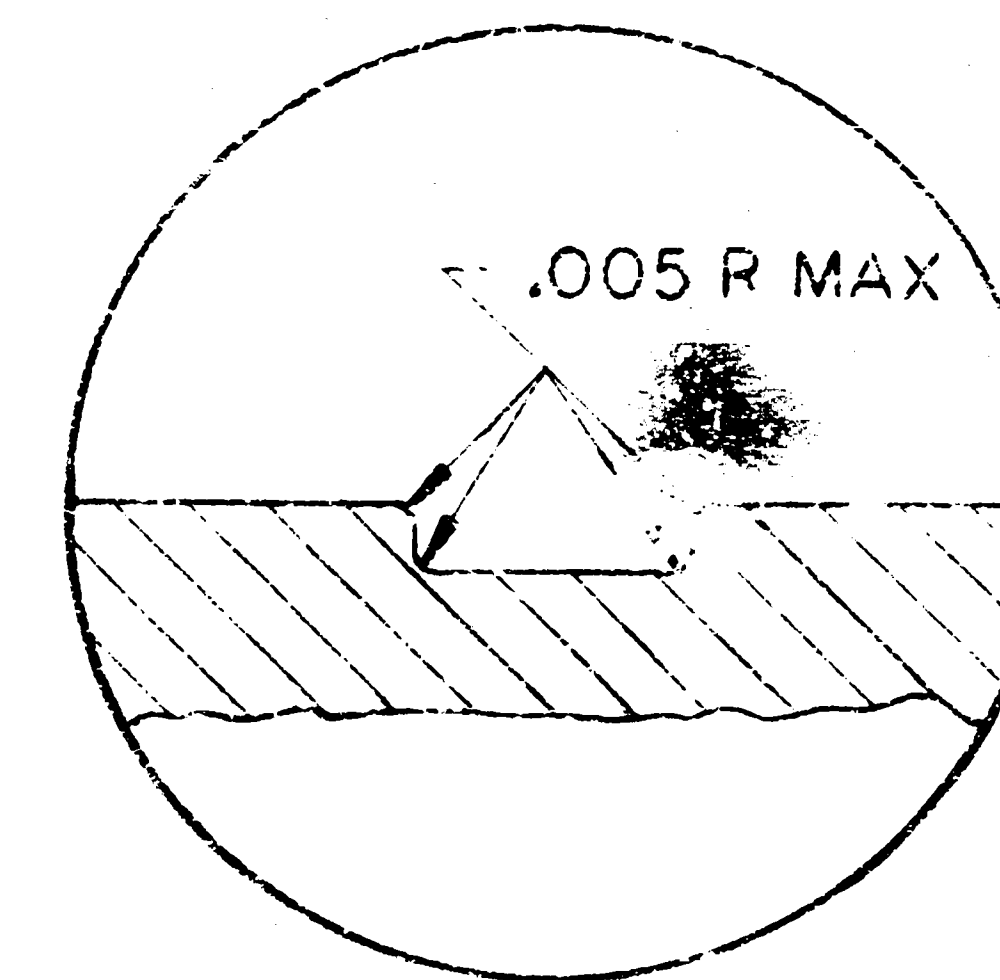
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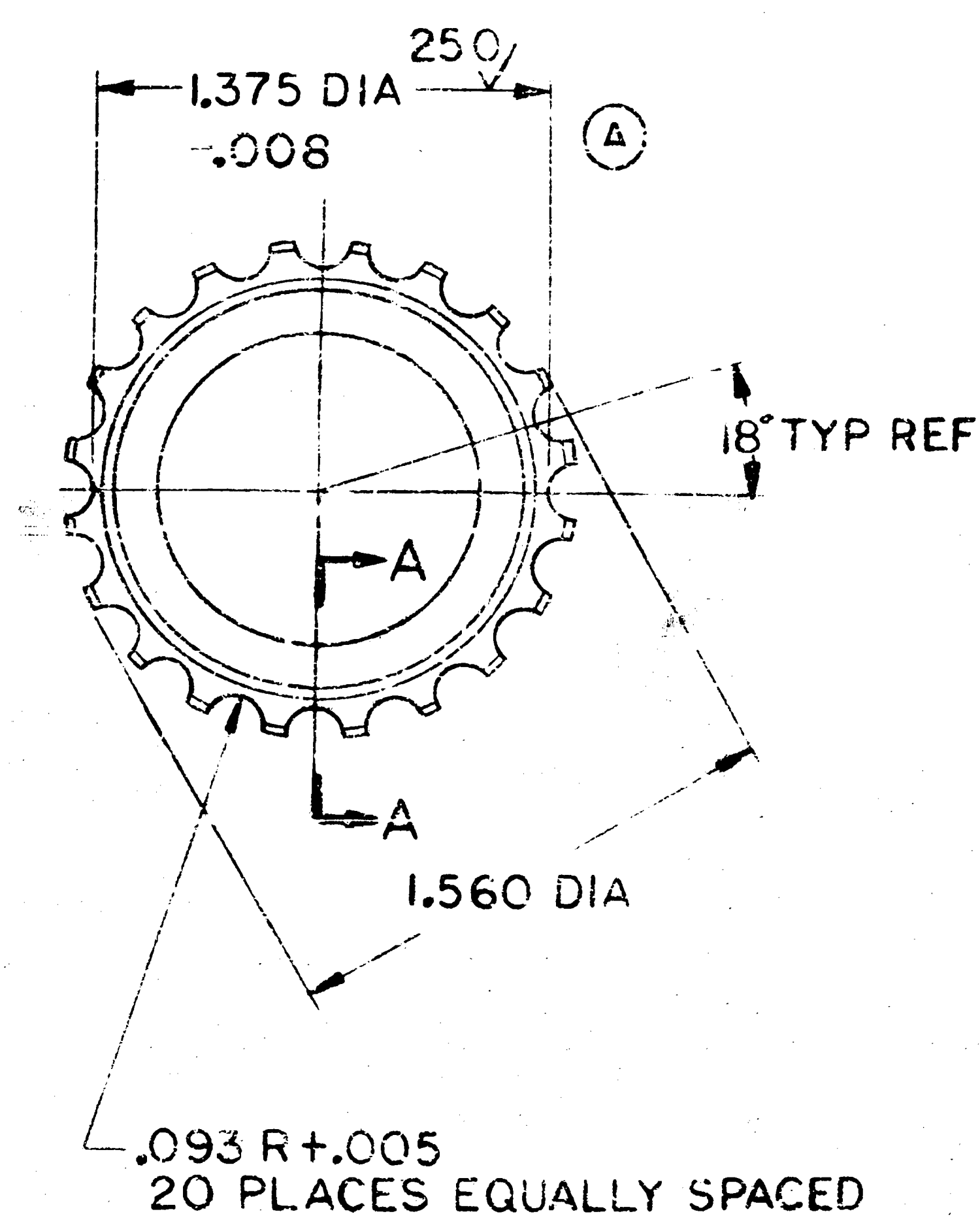
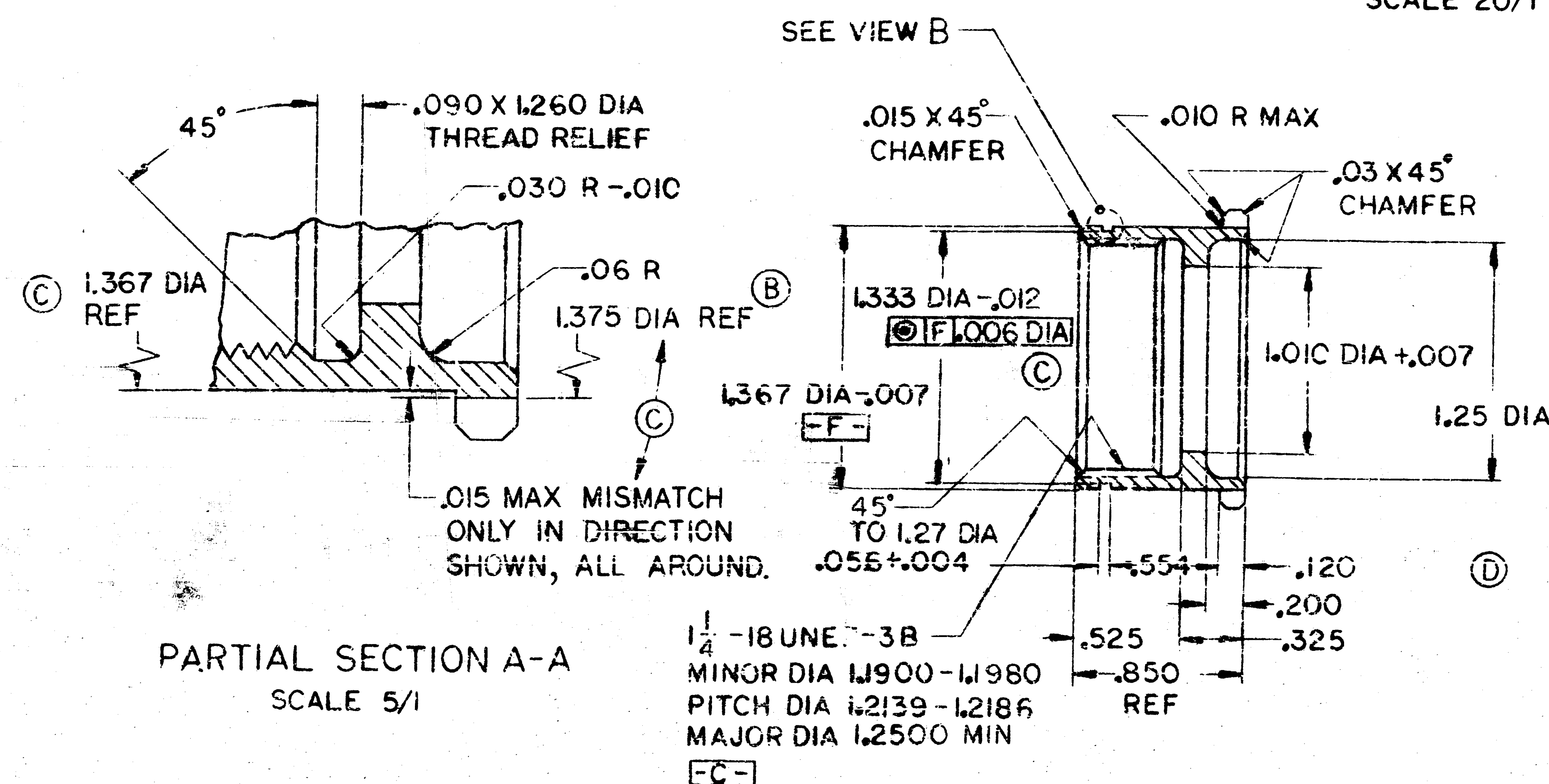
NOTES:

1. STEEL, 4130 ANNEALED, COLD FINISHED, SPEC MIL-S-6758.
2. FINISH ¹²⁵✓ EXCEPT AS NOTED.
3. ALL EDGES SHALL BE BROKEN .005+ .010.
4. ALL DIAMETERS .001-.006 DIA, EXCEPT AS NOTED. (C)
5. FINISH 5.3.1.2 OF MIL-STD-171.
6. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED. (C)
7. MIL-W-13855 APPLIES.

REVISIONS					
NO.	ZONE	LIR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D 61902 REV. A	27 APR 70	
		A	(3) SEE HQY 20639	26 APR 71	✓ B
		D	SEC ERR HQY 20640	5 JUN 72	✓ A
		C	5. SEC ERR HQY 20627	4 JUL 72	✓ A
		(2)	SEE ERR PLAN 20738	16 JAN 74	✓ F3
		E	NOR W952009 30-02-13	10 OCT 15	



VIEW B
SCALE 20/1



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CODE IDENT NO.
19200

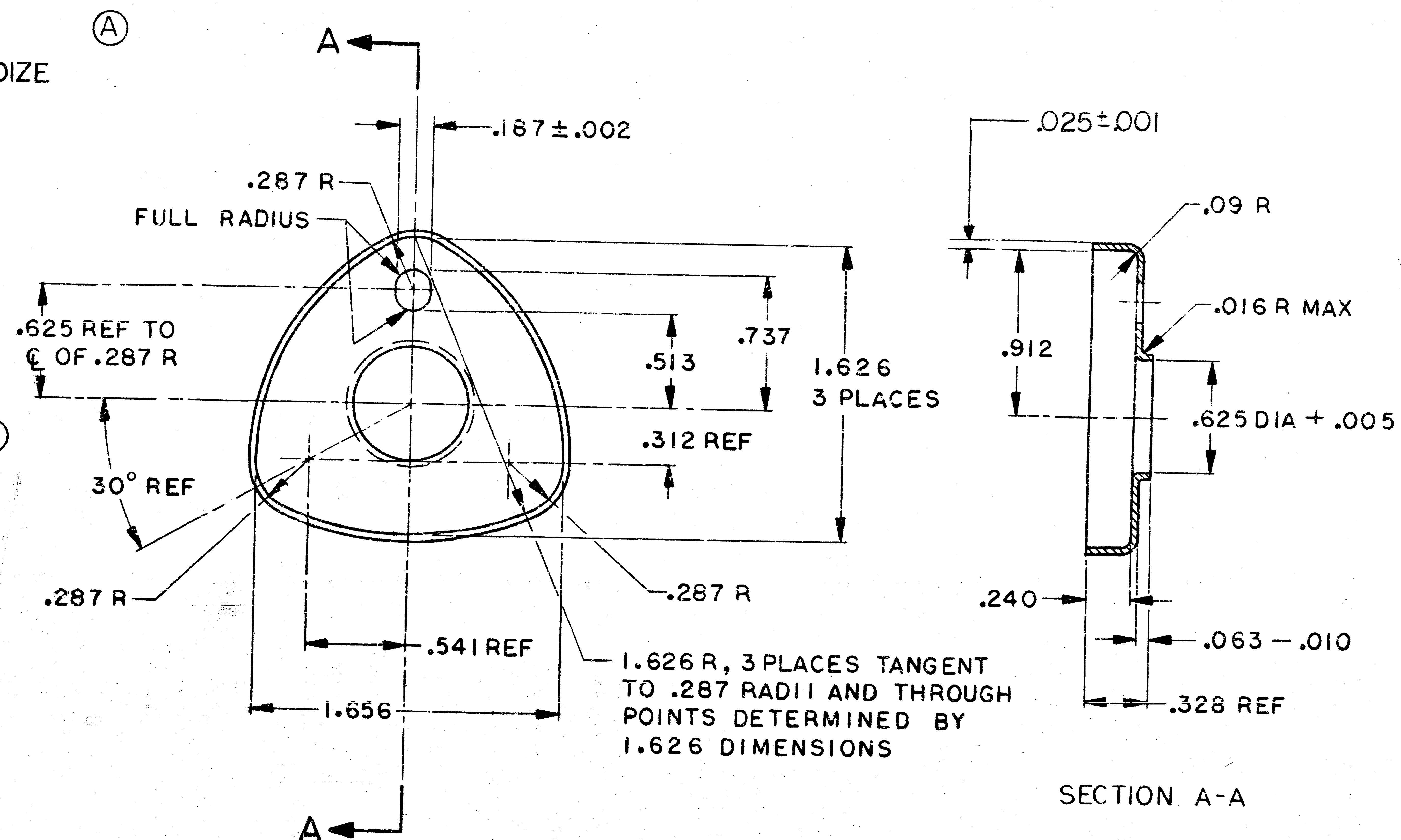
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		<div>OFFICE OF THE ENGINEER</div> <div>ROCK ISLAND ARSENAL, ROCK ISLAND, ILLINOIS</div>	
VS MIN		TOLERANCES		DATE 27 APR 1970		<div>NUT, BARREL</div>	
VS MAX		ANGLES ± 2°		PREPARED <i>W.S. [signature]</i>			
EL 2		3 PLACE DECIMALS ± .005		CHECKED <i>W.S. [signature]</i>			
RA		2 PLACE DECIMALS ± .01		ENGINEER <i>W.S. [signature]</i>			
		MATERIAL		SUBMITTED <i>[signature]</i>		<div>SIZE [] CONT. OF PT. NO. [] DRAWING NO.</div> <div>D 1920-4 8448553</div>	
SH	88448552 M 231	SEE NOTE 1		APPROVED <i>[signature]</i>		<div>SCALE 3/4" = 1"</div> <div>SHEET 1 OF 1</div>	
RN	88448552 M 16A1	SEE NOTE 5					
C26-32		NEXT ASSY USED ON		FINAL PROTECTIVE FINISH			
APPLICATION							

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NOTE:

1. STEEL, CMPSN 1045 THRU 1070, COLD ROLLED, SPHEROIDIZE ANNEALED, SPEC QQ-S-700.
2. FINISH 125/√.
3. BREAK SHARP EDGES .010R MAX.
4. FINISH 5.3.1.2 OF MIL-STD-471.
5. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
6. MIL-W-13855 APPLIES.



CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

CAP, HANDGUARD

SIZE CODE IDENT NO DRAWING NO
C 19204 8448564

SCALE 2/1

SHEET 1 OF 1

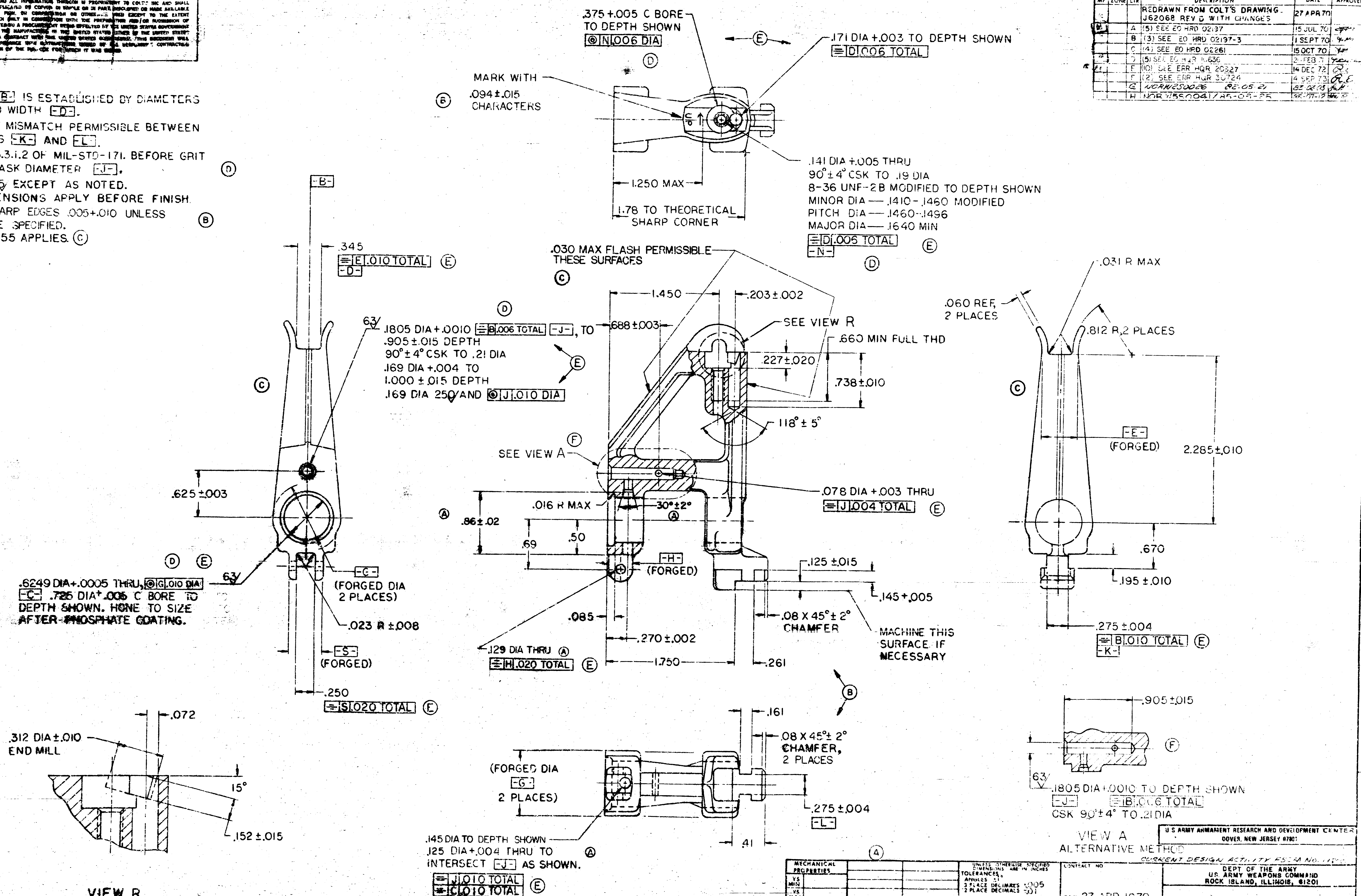
CDI

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
YS MIN		ANGLES ±	
YS MAX		3 PLACE DECIMALS ± .005	
EL 2		2 PLACE DECIMALS ± .01	
RA		MATERIAL	
BH		SEE NOTE 1	
RH	15N 79.5-81.5	FINAL PROTECTIVE FINISH	
		SEE NOTE 4	
		APPLICATION	

CONTRACT NO.	
DATE 27 APR 1970	
PREPARED	39. M
CHECKED	W. J. H.
ENGINEER	W. J. H.
SUBMITTED	F. P. G.
APPROVED	R. J. H.

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1. PLANE [E3] IS ESTABLISHED BY DIAMETERS [E4] AND WIDTH [E5].
2. .005 MAX MISMATCH PERMISSIBLE BETWEEN SURFACES [E6] AND [E7].
3. FINISH, 5.3.1.2 OF MIL-STD-171. BEFORE GRIT BLAST, MASK DIAMETER [E8].
4. FINISH 125, EXCEPT AS NOTED.
5. ALL DIMENSIONS APPLY BEFORE FINISH.
6. BREAK SHARP EDGES .005+.010 UNLESS OTHERWISE SPECIFIED.
7. MIL-W-13855 APPLIES. (C)



REVISIONS					
MT	CON	LTR	DESCRIPTION	DATE	APPROV
			REDRAWN FROM COLT'S DRAWING J62088 REV D WITH CHANGES	27 APR 70	
		A	(1) SEE ED HPO 02137	15 JUL 70	Y
		B	(1) SEE ED HPO 02137-3	15 JUL 70	Y
		C	(1) SEE ED HPO 02081	15 JUL 70	Y
		D	(1) SEE ED HPO 02081	15 JUL 70	Y
		E	(1) SEE ED HPO 02081	15 JUL 70	Y
		F	(1) SEE ED HPO 02081	15 JUL 70	Y
		G	(1) SEE ED HPO 02081	15 JUL 70	Y
		H	(1) SEE ED HPO 02081	15 JUL 70	Y
		I	(1) SEE ED HPO 02081	15 JUL 70	Y
		J	(1) SEE ED HPO 02081	15 JUL 70	Y
		K	(1) SEE ED HPO 02081	15 JUL 70	Y
		L	(1) SEE ED HPO 02081	15 JUL 70	Y
		M	(1) SEE ED HPO 02081	15 JUL 70	Y
		N	(1) SEE ED HPO 02081	15 JUL 70	Y
		O	(1) SEE ED HPO 02081	15 JUL 70	Y
		P	(1) SEE ED HPO 02081	15 JUL 70	Y
		Q	(1) SEE ED HPO 02081	15 JUL 70	Y
		R	(1) SEE ED HPO 02081	15 JUL 70	Y
		S	(1) SEE ED HPO 02081	15 JUL 70	Y
		T	(1) SEE ED HPO 02081	15 JUL 70	Y
		U	(1) SEE ED HPO 02081	15 JUL 70	Y
		V	(1) SEE ED HPO 02081	15 JUL 70	Y
		W	(1) SEE ED HPO 02081	15 JUL 70	Y
		X	(1) SEE ED HPO 02081	15 JUL 70	Y
		Y	(1) SEE ED HPO 02081	15 JUL 70	Y
		Z	(1) SEE ED HPO 02081	15 JUL 70	Y

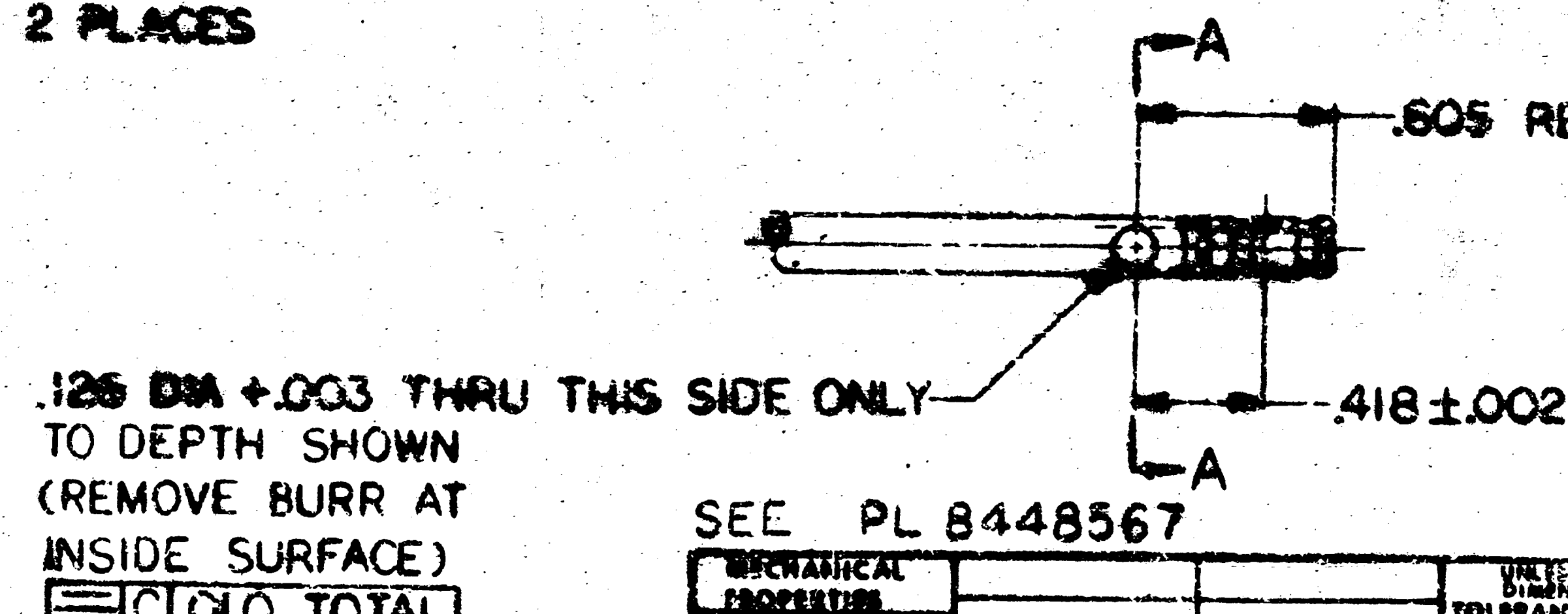
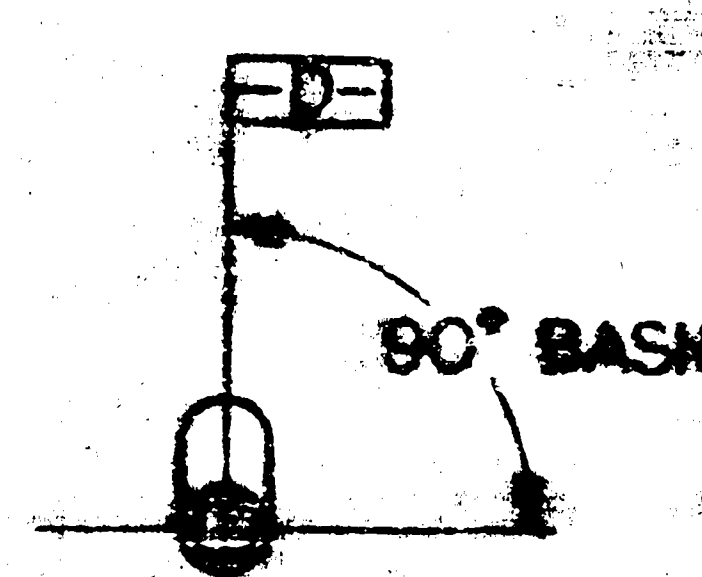
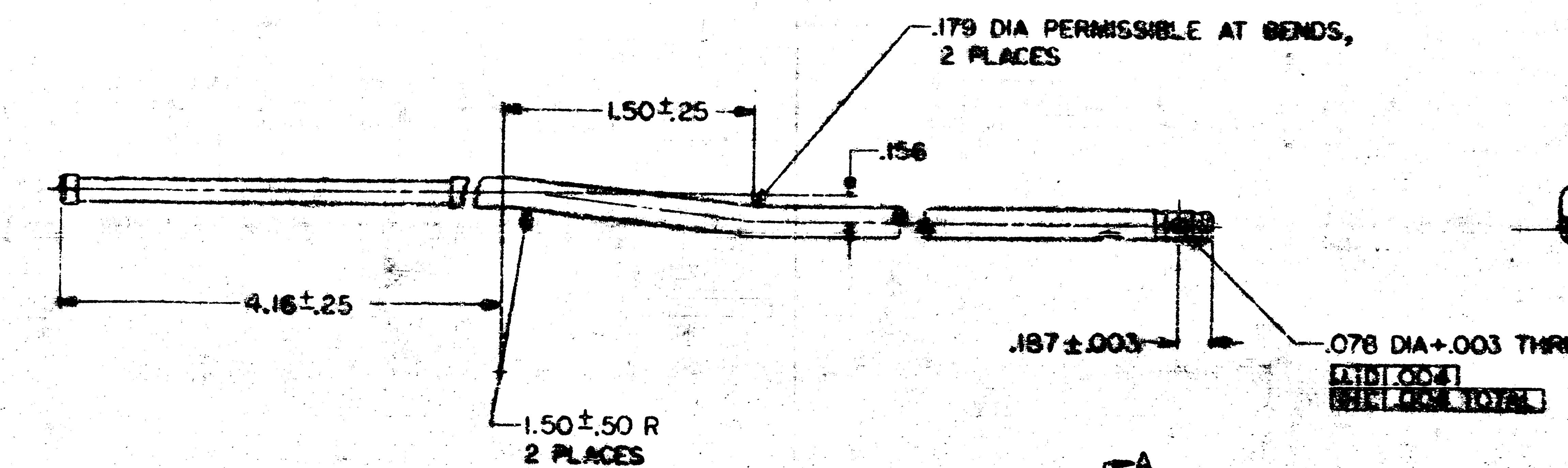
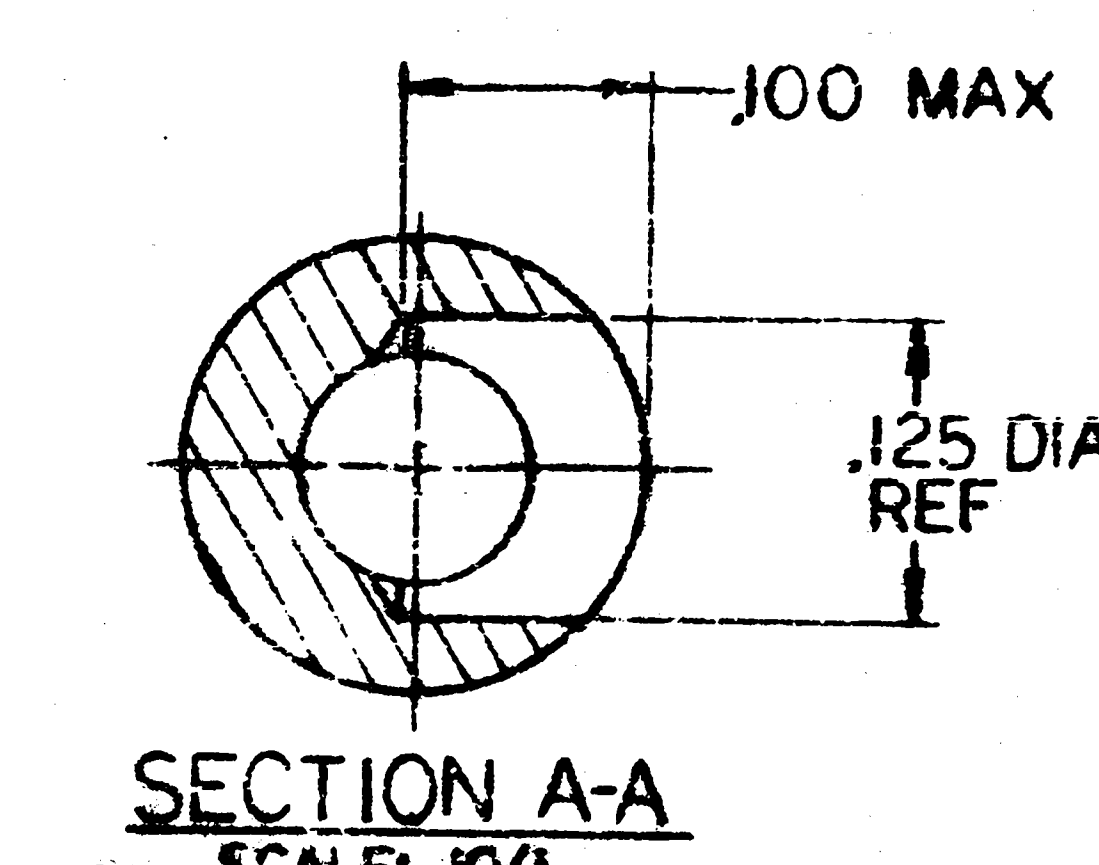
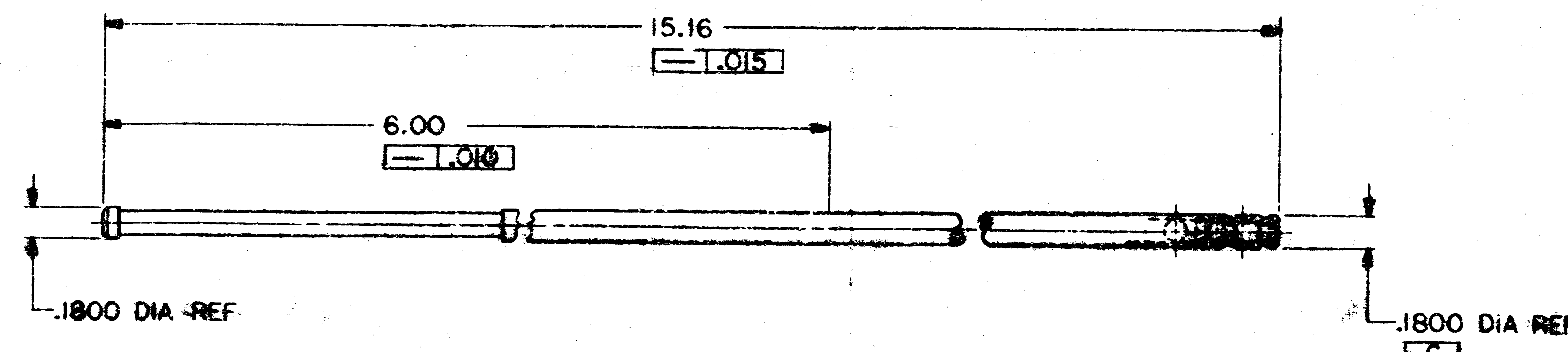
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- NOTE
1. MAKE FROM GAS TUBE AND PLUG ASSEMBLY - 8448568.
 2. FINISH 125.
 3. MIL-W-13855 APPLIES.

REVISIONS				DATE	APPROVED
NO.	DATE	DESCRIPTION	BY	DATE	APPROVED
1		REDRAWN FROM CO. 1'S DRAWING		27 APR 70	
2		DSM 645 REV. W			
3		(1) SEE EO HRD 02197-3		15 JUL 70	
4		(3) SEE ERR HGR 20778		6 OCT 70	
5		WIP NIS 2037		8-12-70	
6		NOR W253258 / 82-12-30		84-05-04	
7		NOR 6853007/880301		881003	



CURRENT DESIGN ACTIVITY
FSCM NO. 19200

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
ROCK HILL, NEW JERSEY 07861

SEE PL 8448567

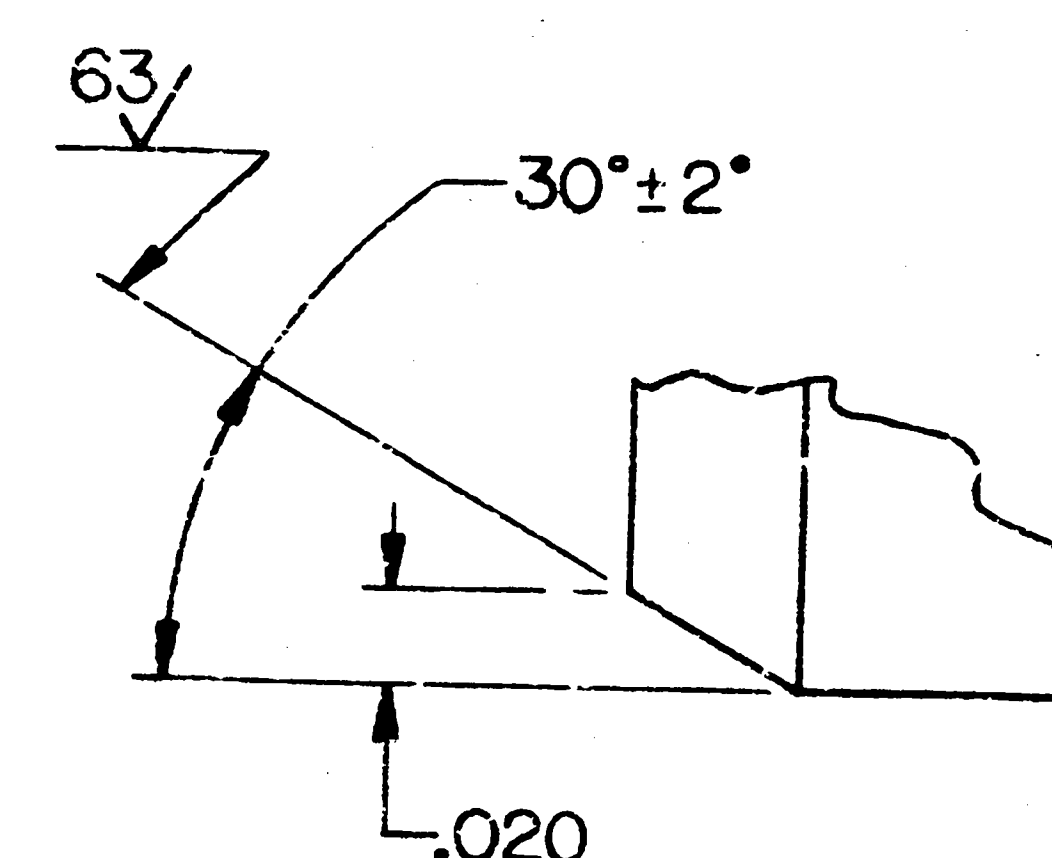
MECHANICAL PROPERTIES		TOLERANCES		DATE 27 APR 1970		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK HILL, NEW JERSEY 07861	
Y1		ANGLES		PERMANENT		GAS TUBE ASSEMBLY	
Y2		3 PLACE DECIMALS	:.005	CHECKED			
Y3		3 PLACE DECIMALS	:.01	DESIGNED		D 19204 8448567	
Y4				APPROVED			
Y5		SEE NOTE 1		APPROVED		CDI	
Y6		S.A. OF MIL-STD-171		APPROVED			
Y7		APPLICATION		APPROVED			

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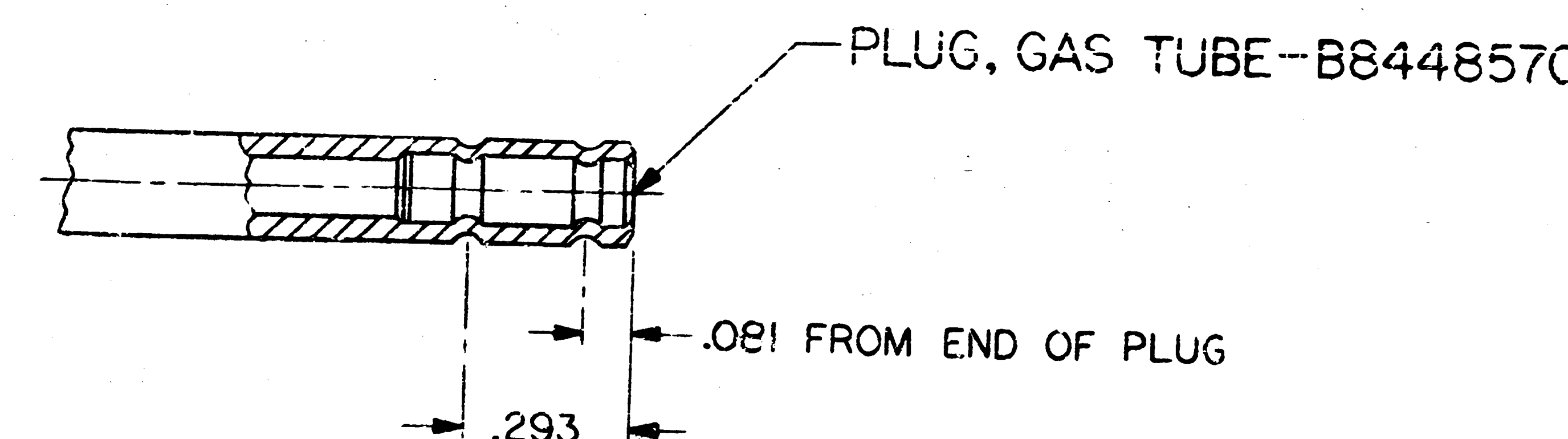
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NOTE:

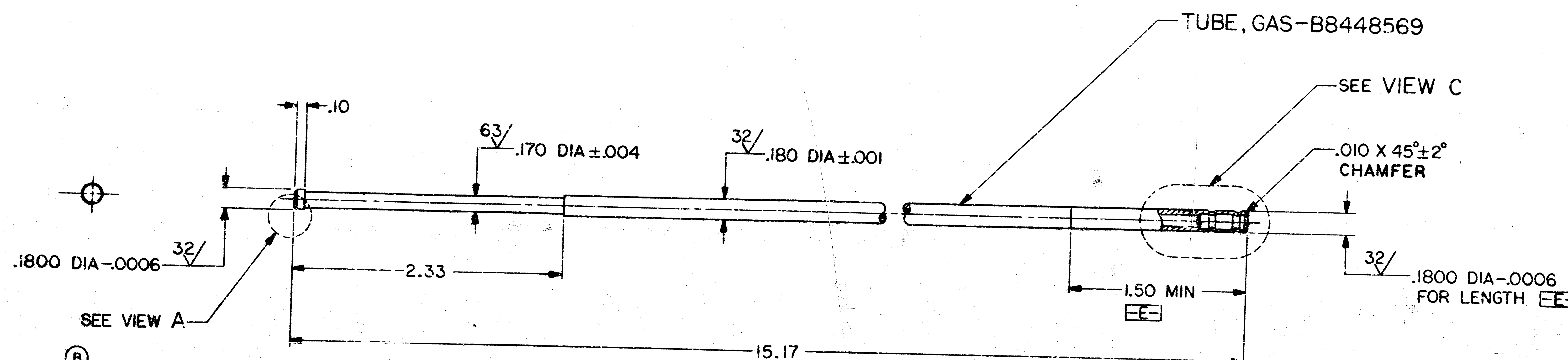
1. INSERT PLUG, GAS TUBE, B8448570 AS SHOWN FLUSH WITH END OF TUBE, GAS, B8448569 WITHIN ± 0.010 PRIOR TO FURTHER MACHINING. SECURELY CRIMP ENTIRE PERIPHERY 2 PLACES AS SHOWN.
2. FACE BOTH ENDS TO BRING TO 15.17 LENGTH.
3. MIL-W-13855 APPLIES.



VIEW A
SCALE 20/1



VIEW C
SCALE 4/1



SEE EPL-8448568

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES: 3 PLACE DECIMALS $\pm .005$ 2 PLACE DECIMALS $\pm .01$		CONTRACT NO.	
YS				DATE 27 APR 1970	
MIN				PREPARED <i>[Signature]</i>	
YS				CHECKED <i>[Signature]</i>	
MAX				ENGINEER <i>[Signature]</i>	
EL2				SUBMITTED <i>[Signature]</i>	
RA				APPROVED <i>[Signature]</i>	
BH				SCALE 2/1	
RH				SHEET 1 OF 1	
D8448567		MIG		D 19204	
NEXT ASSY		USED ON		DRAWING NO. 8448568	
APPLICATION		FINAL PROTECTIVE FINISH		CDI	

5 4 3 2 1

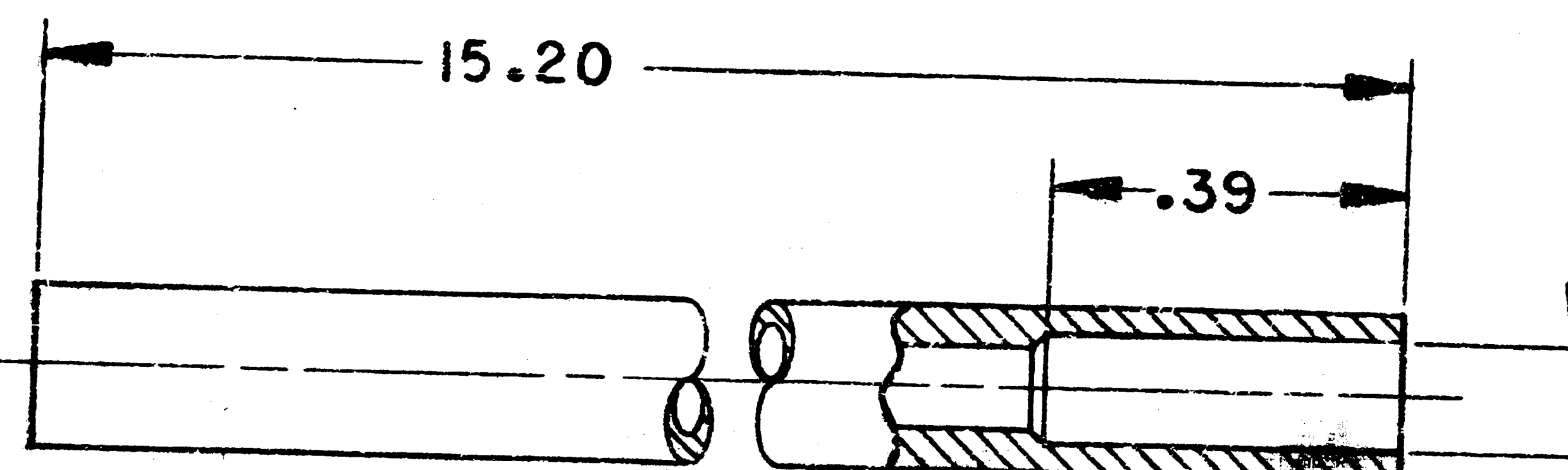
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REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
			REDRAWN FROM COLT'S DRAWING B61789 REVISION A	27 APR 70
	A		(1) SEE EO HRD 02197-3	15 JULY 70
	B		(2) SEE ERR HQR 20778	6 OCT 72
	C		NORW 280026	82-05-21
				53-02-03

NOTES:

- TUBING, STEEL, CORROSION-RESISTANT (304), TYPE I, ROUND, .187 O.D. +.005, .0350 ± .0055 WALL THICKNESS, 1/2 H-COLD DRAWN, SPEC MIL-T-5695.
- FINISH 125/.
- MIL-W-13855 APPLIES. (B)



.125 DIA +.001
DIMENSION .39 APPLIES
ONLY WHEN RESULTING
I.D. OF TUBING IS LESS
THAN .125 DIA

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY	
YS MIN		TOLERANCES:		DATE 27 APR 1970		U.S. ARMY WEAPONS COMMAND	
YS MAX		ANGLES ±		PREP RGR 9-9-70		ROCK ISLAND, ILLINOIS, 61201	
EL 2		3 PLACE DECIMALS ±		CHK RGR 9-9-70		TUBE, GAS	
RA		2 PLACE DECIMALS ± .01		ENGR R. J. Henry			
BH		MATERIAL		SUBMITTED			
RH		D8448568 M16		SEE NOTE 1		SIZE B	
NEXT ASSY		USED ON		FINAL PROTECTIVE FINISH		CODE IDENT NO. 19204	
APPLICATION				APPROVED R. J. Henry		DRAWING NO. 8448569	
						SCALE 4/1	
						SHEET 1 OF 1	

AMSWE Form 403B, 29 Jul 69

CDI

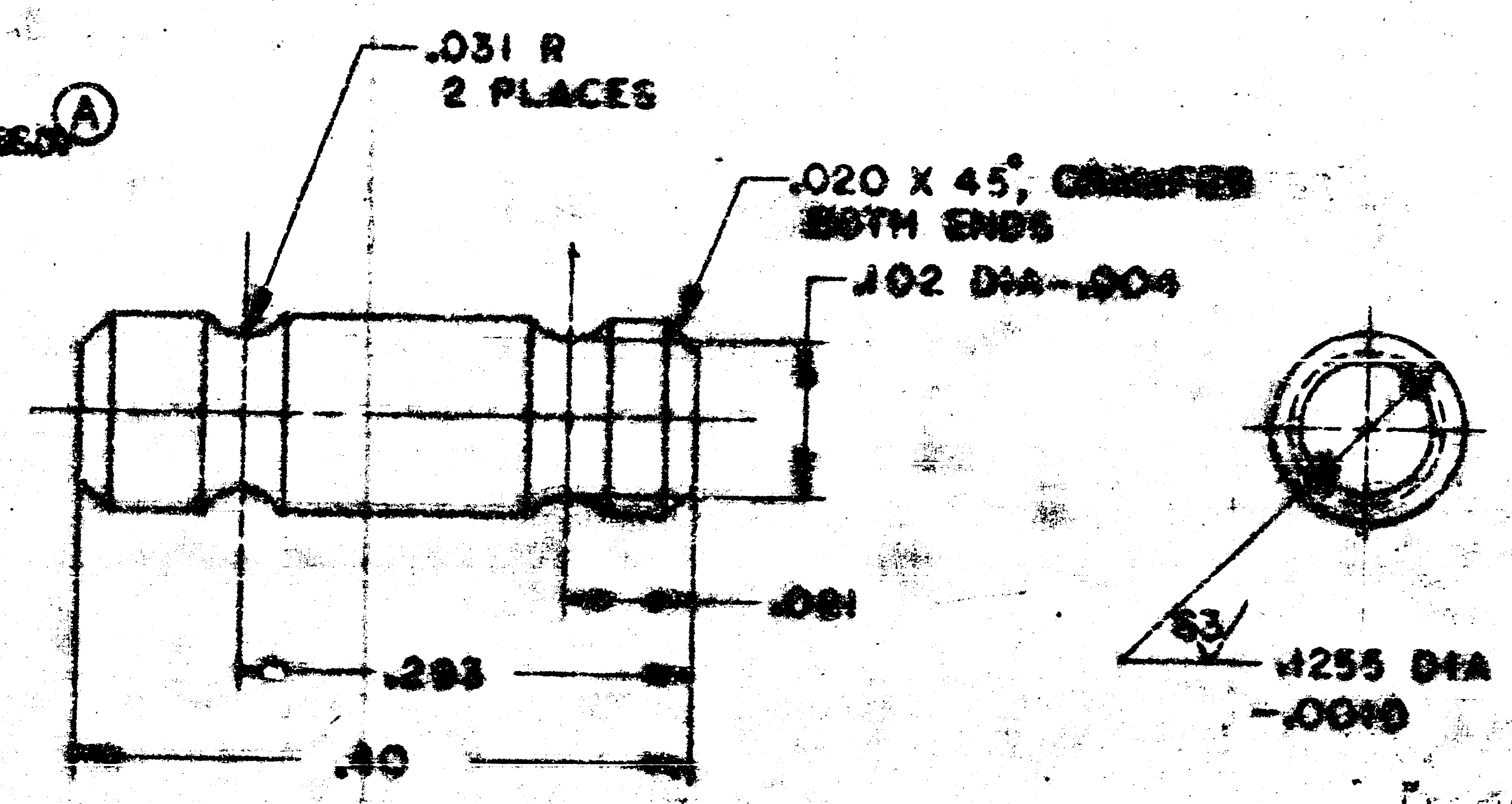
B 8448569

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REVISIONS				
REV	DATE	DESCRIPTION	DATE	APPROVED
1		REDRAWN FROM COLT'S DRAWING	27 APR 70	
2		C61644 REVISION A		
3		(2) SEE ENR MOR 20778	6 OCT 72	R.C.
4		100-223-0026	08-03-21	08-02-01
5		C. MOR 6852007/880329	080926	080926

- NOTES:
1. WIRE, STEEL, CORROSION RESISTING, CIPEN 302, 304 OR 321, CONDITION A, SPEC ASTM-A560. (A)
 2. FINISH 125/ EXCEPT AS NOTED.
 3. FINISH 5.4.1 OF MIL-STD-171.
 4. MIL-W-18885 APPLIES. (A)



ORIGINAL DESIGN ACTIVITY FSCM NO. 19200

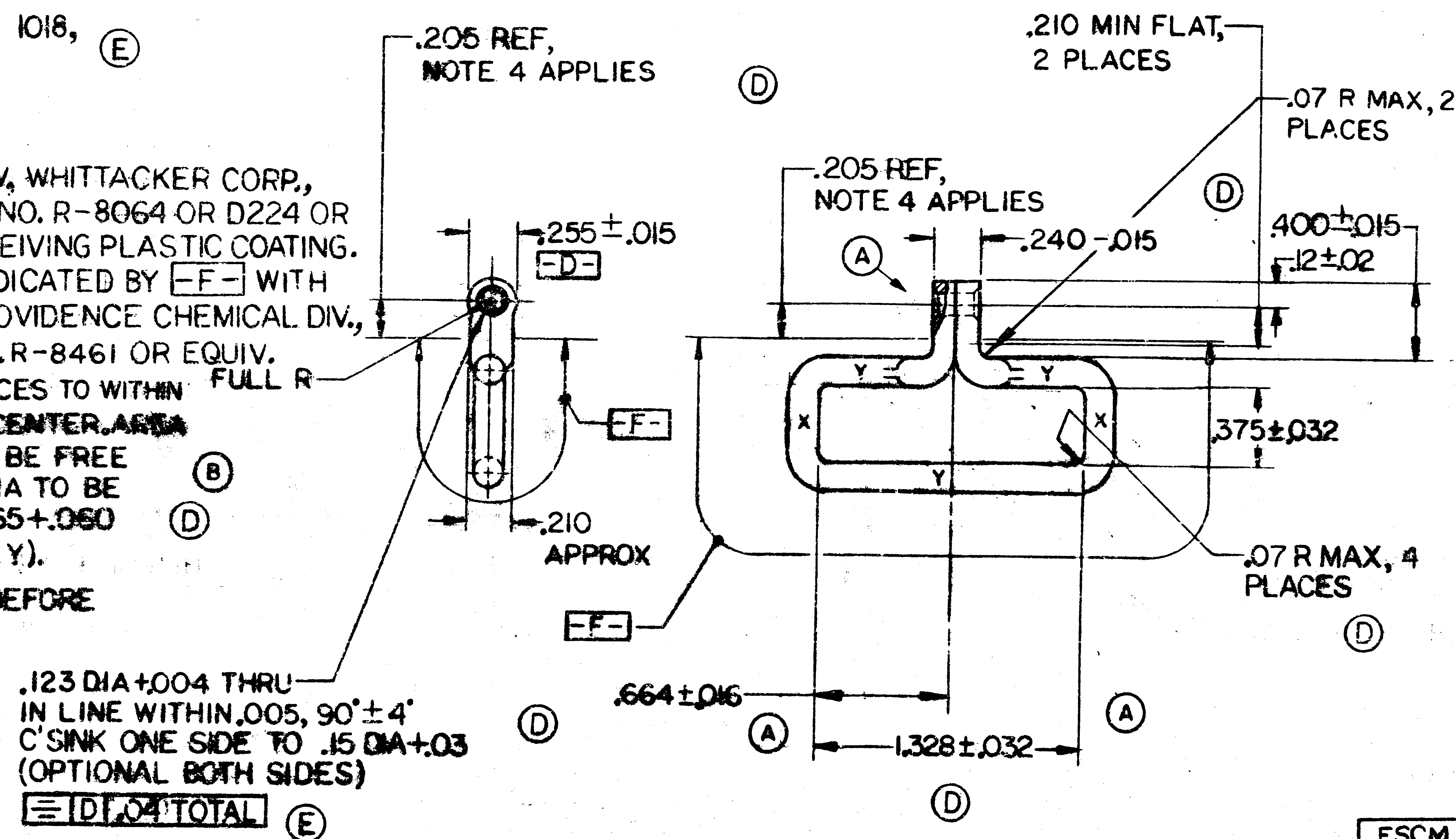
U.S. ARMY WEAPONS COMMAND AND DEVELOPMENT CENTER

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DATE		27 APR 1970	
YS				TOLERANCES		FRACTIONAL		DECIMALS	
MIN				ANGLES		3 PLACE		2 PLACE	
MAX				DECIMALS		1.005		1.01	
EL 2				DECIMALS		1.01		1.01	
RA				DECIMALS		1.01		1.01	
BH				DECIMALS		1.01		1.01	
RH				DECIMALS		1.01		1.01	
		MIG		SEE NOTE 1		DATE		27 APR 1970	
		08448568 MIGAI		SEE NOTE 3		PREP		R.G. A.C.	
		NEXT ASSY		USED ON		CHK		R.G. A.C.	
		APPLICATION				ENGR		R.G. A.C.	
						DATE		27 APR 1970	
						PREP		R.G. A.C.	
						CHK		R.G. A.C.	
						ENGR		R.G. A.C.	
						DATE		27 APR 1970	
						PREP		R.G. A.C.	
						CHK		R.G. A.C.	
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						PREP		R.G. A.C.	
						CHK		R.G. A.C.	

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REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D62280 REV B	27 APR 70	
M		A	(4) SEE EO HRD-02197	15 JULY 70	<i>[Signature]</i>
		B	(2) SEE EO HRD 02197-3	1 SEPT 70	<i>[Signature]</i>
		C	SEE ERR HQR 10822	9 AUG 71	<i>[Signature]</i>
		D	(6) SEE ERR HQR 20652	9 APR 72	<i>[Signature]</i>
M		E	(2) SEE ERR HQR 20827	14 DEC 72	<i>[Signature]</i>
		F	NOR W9S2009 80-02-13	80-0516	<i>[Signature]</i>
		G	NOR W4S 0024/84-10-17	85-01-25	<i>[Signature]</i>

1. WIRE, STEEL, CMPSN 1010 OR 1018, .156 DIA, ASTM A545. (E)
2. FINISH 63/.
3. APPLY PROVIDENCE CHEMICAL DIV, WHITTACKER CORP., ADHESIVE PRIMER COMPOUND NO. R-8064 OR D224 OR EQUIV., TO ALL SURFACES RECEIVING PLASTIC COATING. THEN DIP COAT ALL AREAS INDICATED BY F WITH FLAT BLACK CHEM-O-SOL, PROVIDENCE CHEMICAL DIV., WHITTACKER CORP., COMPOUND NO. R-8461 OR EQUIV.
4. CHEM-O-SOL COAT ALL SURFACES TO WITHIN FULL R B $205 \pm .025$ OF MOUNTING HOLE CENTER AREA. AROUND MOUNTING HOLE MUST BE FREE OF COATING. PLASTIC COATED DIA TO BE $.165 + .040$ (2) VERT LEGS (X) $.165 + .060$ D ON (3) HORIZONTAL SECTIONS (Y).
5. FINISH 5.3.1.3 OF MIL-STD-171 BEFORE FINISH SPECIFIED IN NOTE 3.
6. TOOL AND FORMING MARKS PERMISSIBLE PRIOR TO CHEM-O-SOL COATING, PROVIDED COATING IS NOT DEGRADED TO THE EXTENT OF SURFACE DISCONTINUITIES. $.123 \text{ DIA} + .004$ THRU IN LINE WITHIN .005, 90° C'SINK ONE SIDE TO .15 (OPTIONAL BOTH SIDES) E .04 TOTAL
7. MIL-W-13855 APPLIES.



FSCM NO.
19200

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO:		DOVER, NEW JERSEY 07801	
YS MIN				TOLERANCES:		DATE 27 APR 1970		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MAX				ANGLES: 2					
EL 2				3 PLACE DECIMALS: 005					
RA				2 PLACE DECIMALS:					
BH				MATERIAL		PREPARED: <i>J.E.W.</i> <i>A. J. M.</i> CHECKED: <i>W.H.</i> <i>S. J. M.</i> ENGINEER: <i>W.H.</i> <i>E. J. M.</i> SUBMITTED: <i>F. P. Gilchrist</i>		SWIVEL, SLING	
RH		C8448565 M16		SEE NOTE 1		APPROVED: <i>R. S. Henry</i>		SIZE: C CODE IDENT NO: 19204 DRAWING NO: 8448571	
		C8448565 M16A1		FINAL PROTECTIVE FINISH				SCALE: 2/1 SHEET: OF:	
		NEXT ASSY USED ON		SEE NOTES 3, 4 AND 5					
		APPLICATION							

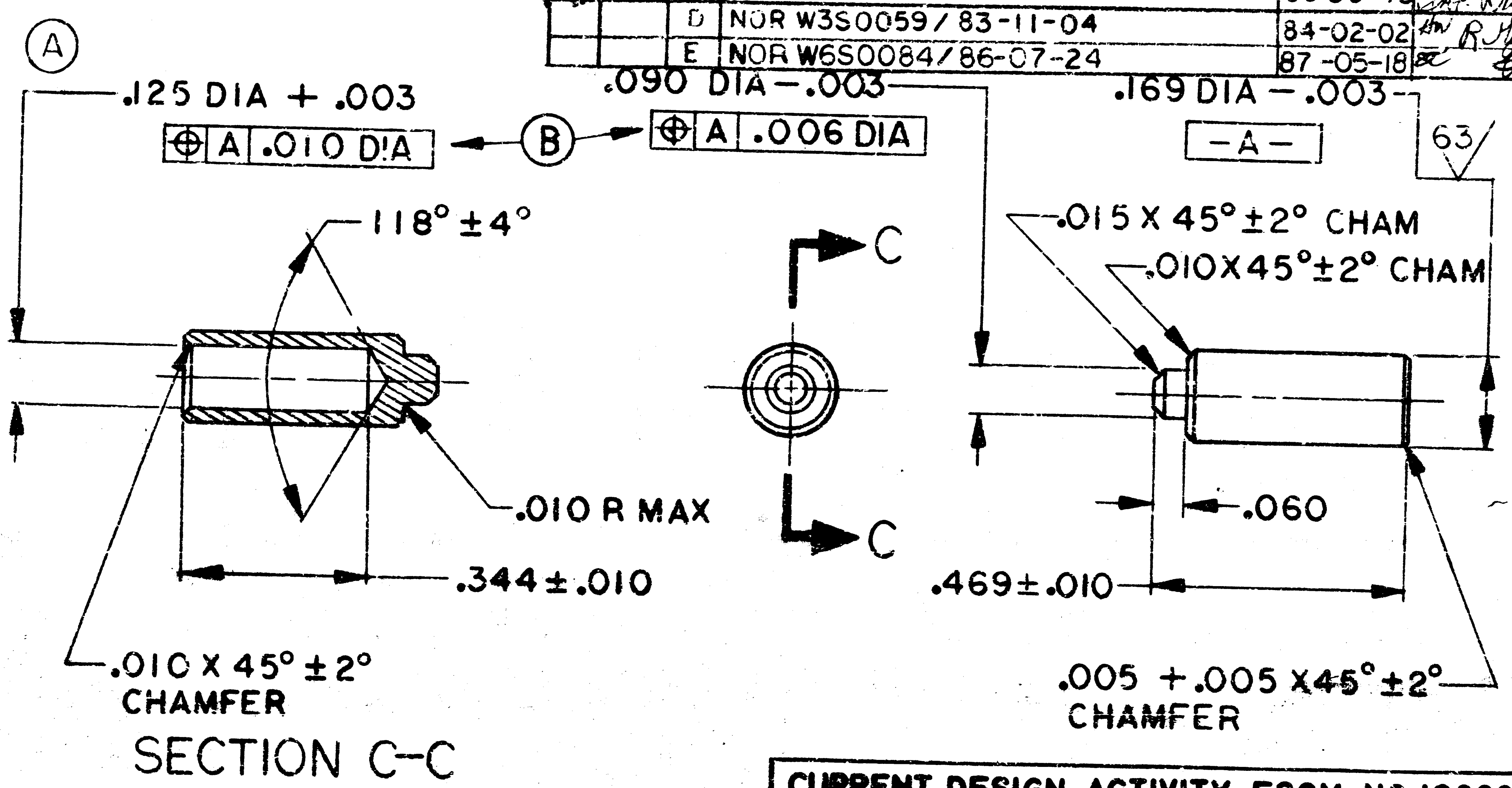
CDI

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- NOTES:
1. FINISH $\sqrt{125}$ EXCEPT AS NOTED.
 2. FINISH 5.3.1.2 OF MIL-STD-171.
 3. BREAK SHARP EDGES .005+.010.
 4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
 5. MIL-W-13855 APPLIES.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
			REDRAWN FROM COLT'S DRAWING	
			C61705 REVISION C	27 APR 70
	A		(1) SEE EO HRD 02197-3	15 JUL 70
	B		(4) SEE ERR HQR 20827	14 DEC 72
	C		NOR W9S2009 80-02-13	80-05-18
	D		NOR W3S0059/83-11-04	84-02-02
	E		NOR W6S0084/86-07-24	87-05-18



CURRENT DESIGN ACTIVITY FSCM NO.19200
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY	
YS MIN		ANGLES		DATE	27 APR 1970	US ARMY WEAPONS COMMAND	
YS MAX		3 PLACE DECIMALS ± .005		PREP		ROCK ISLAND, ILLINOIS, 61201	
EL 2		2 PLACE DECIMALS ±		CHK		DETENT, FRONT SIGHT	
RA				ENGR			
BH		MATERIAL		SUBMITTED		SIZE	CODE IDENT NO.
RH	15N 72.5-76	WIRE, CMPSN 4130, ASTM A322 OR A331		APPROVED		B	19204
		NEXT ASSY	USED ON	F. P. Yellow		DRAWING NO.	
		APPLICATION		R. S. Henry		8448573	
						SCALE	4/1
						SHEET 1 OF 1	

5 4 3 2 1

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REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
11-		B	REPLACES REV A W/CHANGE SEE ERR HQR 20827	14 DEC 72
		C	NORWEL8001 / 82-04-13 (ECPW250034 / 82-07-15) (ECPW353120 / 83-07-07)	83-11-04

SPRING, HELICAL, COMPRESSION

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 303 (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO COND TN CH900. HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BREAK SHARP EDGES .003 ± .012.

WIRE DIAMETER _____ .0180 ± .0005
COIL DIAMETER (O.D) _____ .115 ± .003
FREE LENGTH _____ .75 REF
TOTAL COILS _____ 20 REF
DIRECTION OF HELIX _____ OPTIONAL
LOAD AT COMPRESSED LENGTH OF .557 AFTER SET _____ 1.78 LB ± .18 LB
LOAD AT COMPRESSED LENGTH OF _____
SPRING RATE _____
SOLID LENGTH _____ .390 MAX
TYPE OF ENDS _____ CLOSED
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

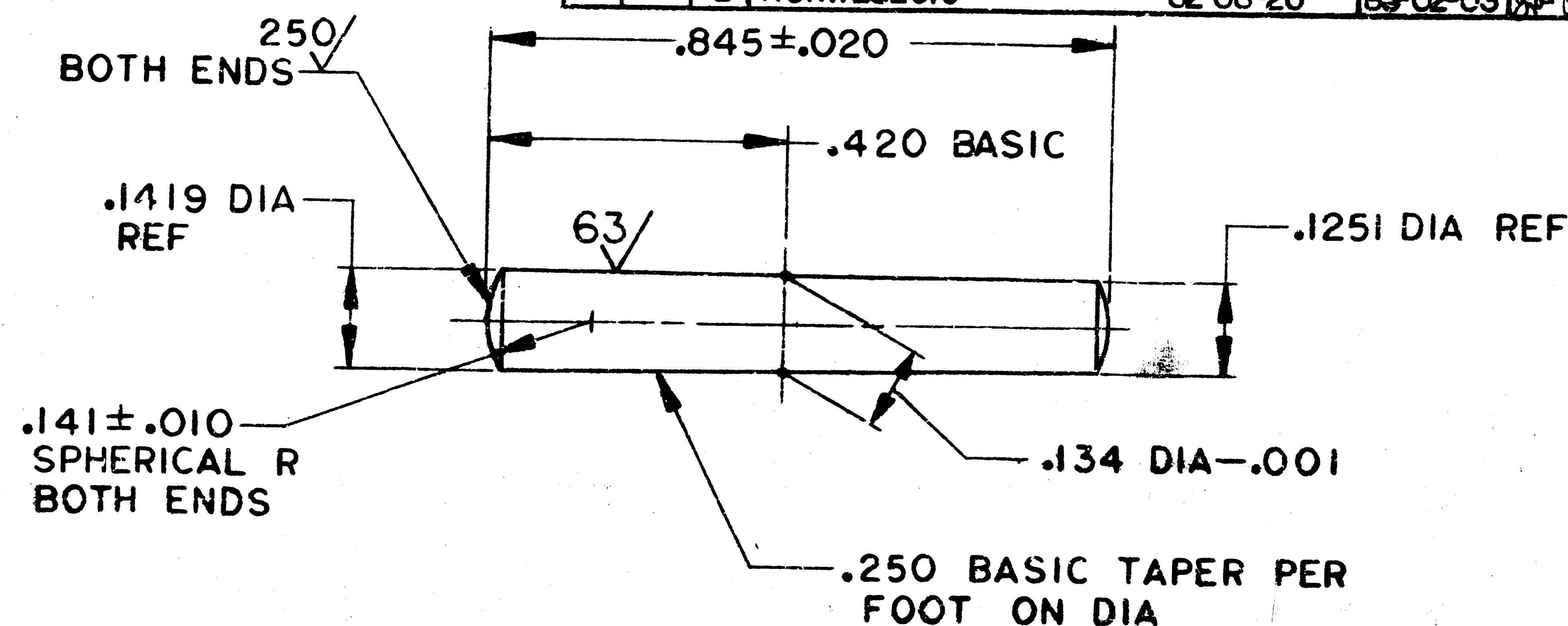
CURRENT DESIGN ACTIVITY
FSCM No. 19200
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		PART NO. 8448574	
YS MIN		TOLERANCES:		DATE 27 APR 70		DEPT OF THE ARMY	
YS MAX		ANGLES: 1 -		PREP P. Verma H. Gorman		U.S. ARMY WEAPONS COMMAND	
EL 2		3 PLACE DECIMALS ± .005		CHK W. D. H. W. H. W. H.		ROCK ISLAND, ILLINOIS, 61201	
RA		2 PLACE DECIMALS ± .01		ENGR R. E. L. R. E. L.		SPRING, FRONT	
BH		F8448601	M16	SUBMITTED		SIGHT DETENT	
RH	15N 845 MIN	F8448522	M16 A1	APPROVED		SIZE B	CODE IDENT NO. 19204
		NEXT ASSY	USED ON	5.4.1 OF MIL-STD-171		DRAWING NO. 8448574	
		APPLICATION				SCALE	SHEET OF

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NOTE:

1. SUGGESTED HEAT TREAT:
LIQUID CARBURIZE AT
1550°F TO OBTAIN A
TOTAL CASE DEPTH OF
.010/.015.
2. BREAK SHARP EDGES
.005±.010.
3. STEEL, CMPSN 4027, 4028,
AND 4037, SPEC ASTM A304
OR STEEL, CMPSN 1030,
1033, 1035, AND 1037, SPEC
ASTM A108.
4. MIL-W-13855 APPLIES.



REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
			REDRAWN FROM COLT'S DRAWING	
			C62086 REVISION B	27 APR 70
		A	SEE ERR HQR 20714	13 JUL 72
		B	(2) SEE ERR HQR 20827	14 DEC 72
		C	(1) SEE ERR HQR 50625	18 MAR 75
		D	NOR W9S2009 80-02-13	80-05-16
		E	NORW2S2015	82-08-20

CURRENT

CODE IDENT NO.
19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		U S ARMY WEAPONS COMMAND	
YS MIN		TOLERANCES:		DATE 27 APR 1970		ROCK ISLAND, ILLINOIS, 61201	
YS MAX		ANGLES:		PREP RGA		PIN, TAPER, FRONT SIGHT	
EL 2		3 PLACE DECIMALS ± .005		CHK RGA		SIZE B	
RA	F8448601 M16	2 PLACE DECIMALS ±		ENGR J. P. Kelly		CODE IDENT NO. 19204	
BH	F8448522 M16A1			SUBMITTED		DRAWING NO. 8448575	
RH	15N 89-91	APPLICATION		APPROVED R. P. Kelly		SCALE 5/1	
						SHEET 1 OF 1	

AMSWE Form 403B, 29 Jul 69

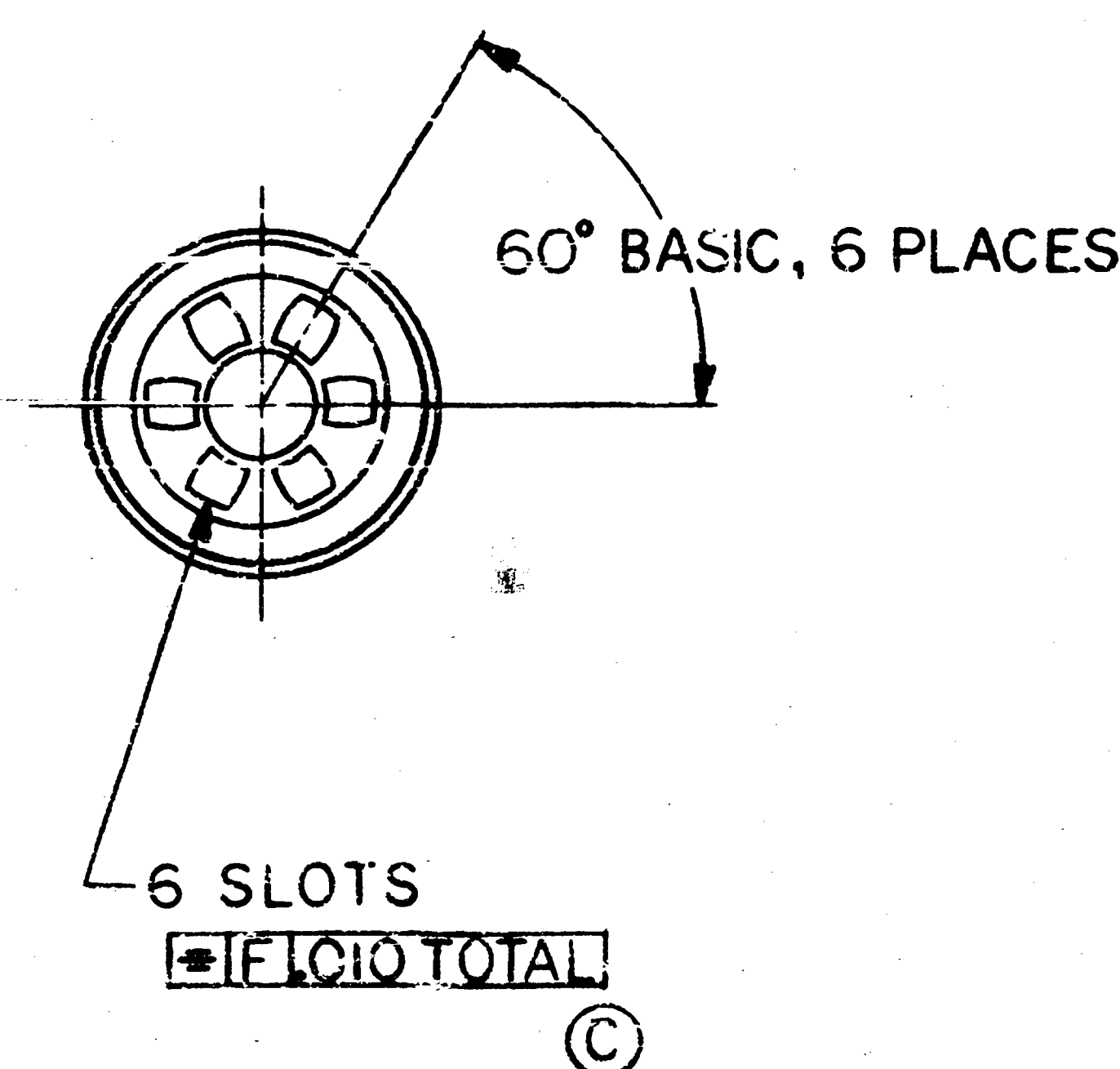
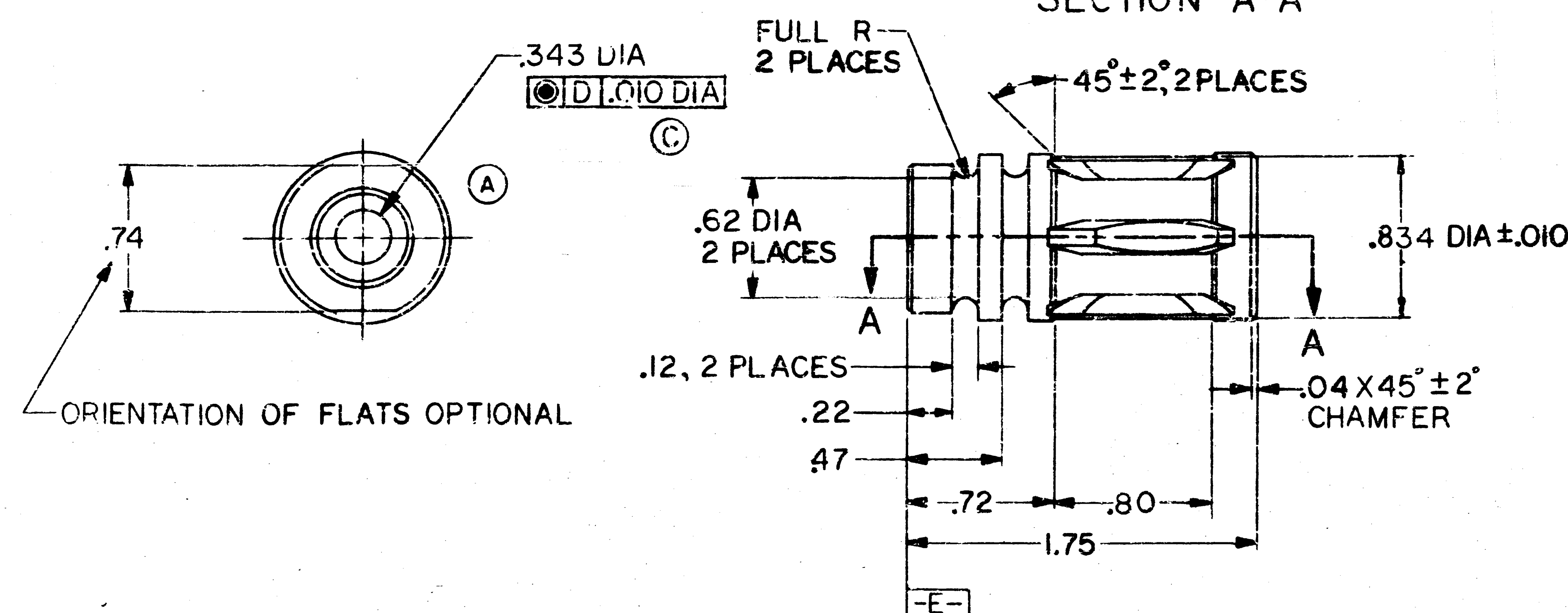
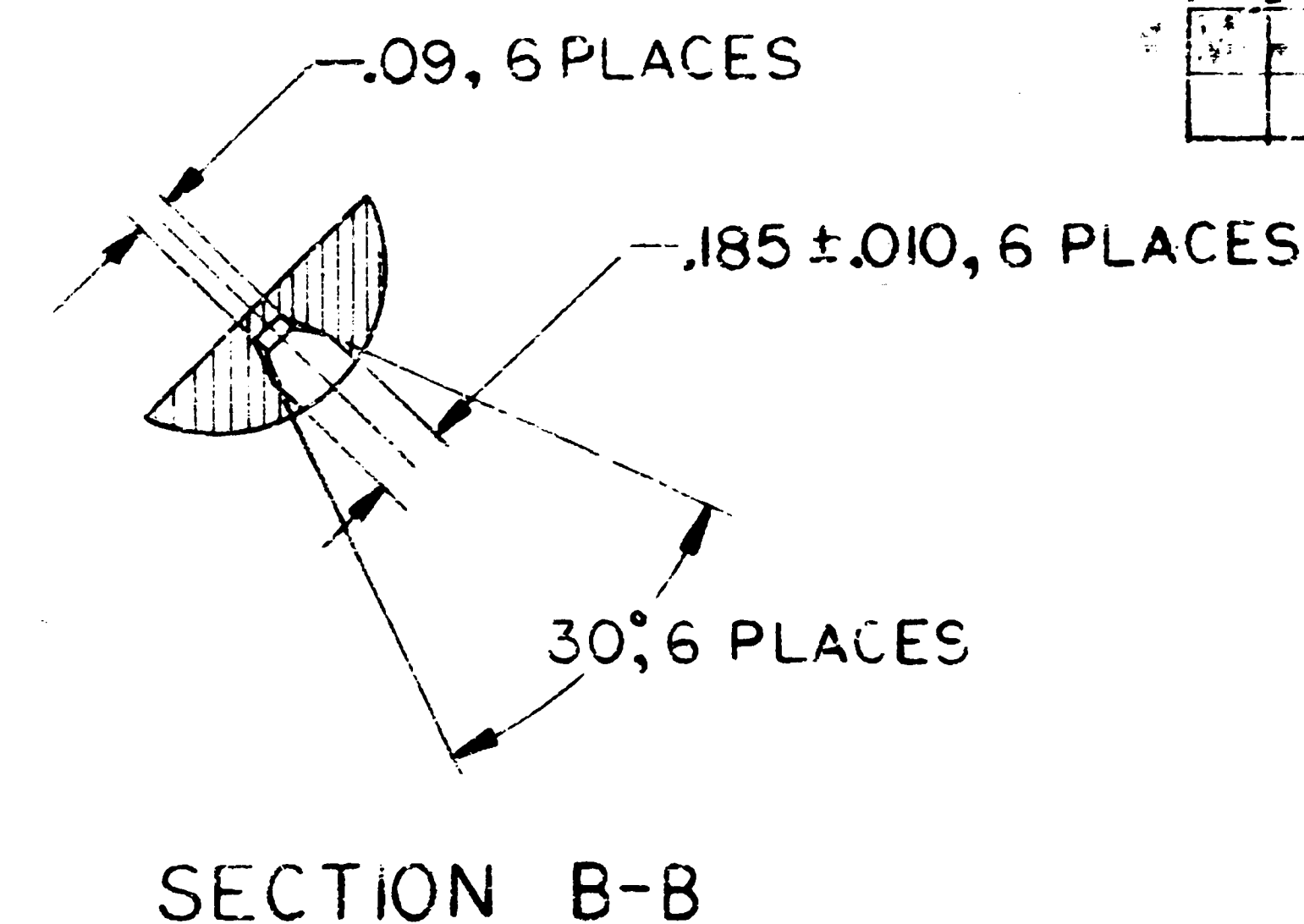
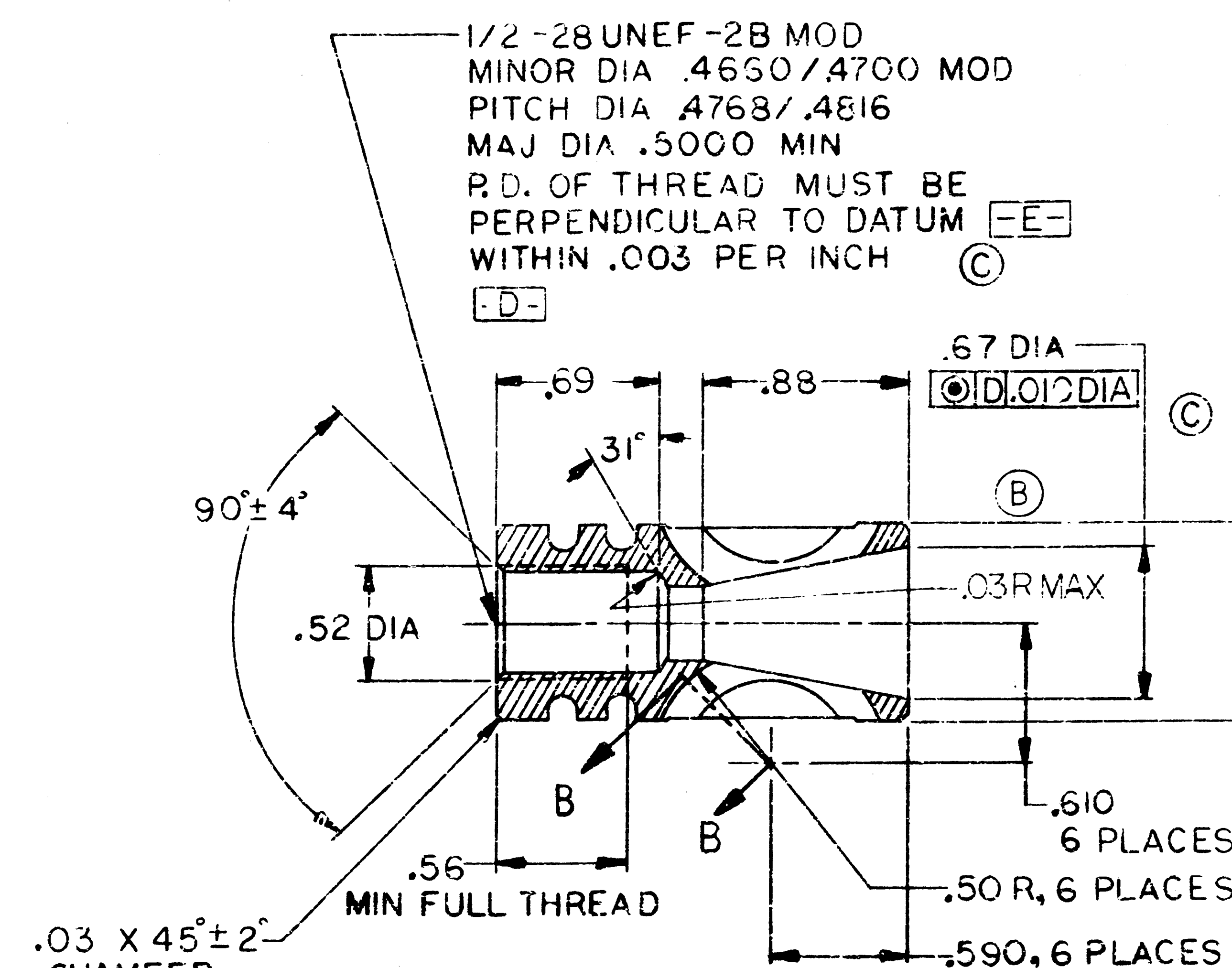
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8 7 6 5 4 3 2 1

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- NOTE:
1. FINISH 125/ EXCEPT AS NOTED.
 2. ALL OUTSIDE DIAMETERS FLODIA (C)
 3. BREAK SHARP EDGES .005 - .010.
 4. MIL-W-13885 APPLIES. (B)



REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
			REDRAWN FROM COLT'S DRAWING D62348 REV A	27 APR 70
	A	(2)	SEE EO HRD 02197-3	15 JUL 70
	B	(2)	SEE EO HQR 10621	20 FEB 71
	C	(6)	SEE ERR HQR 20775	8 OCT 72
	D		NOR W9S2009 80-02-13	80-05-16

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.	
YS MIN		TOLERANCES		DATE	27 APR 1970
YS MAX		ANGLES		PREPARED	
EL 2		3 PLACE DECIMALS ±.005		CHECKED	
RA		2 PLACE DECIMALS ±.01		ENGINEER	
BH		MATERIAL	STEEL AISI 4130 OR 4130	SUBMITTED	
RM	C26-32	FINISH	5.3.1.2 OF MIL-STD-171	APPROVED	
APPLICATION		NEXT ASSY USED ON		DRAWING NO. 8448576	

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19200

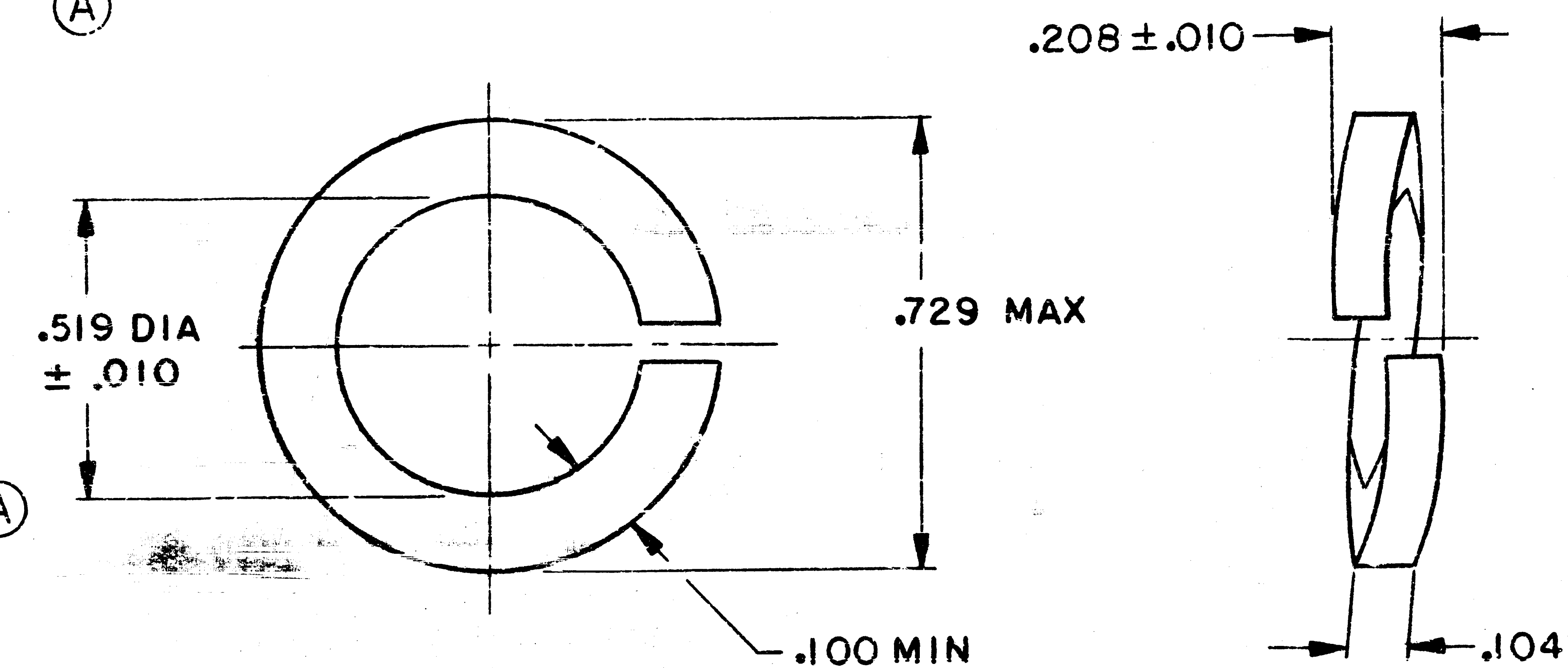
SUPPRESSOR, FLASH

SIZE CODE IDENT NO. DRAWING NO. D 19200 8448576

SCALE 2:1

SHEET 1 OF 1

CDI

5	4	3	2	1																																																																									
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<p>NOTE:</p> <ol style="list-style-type: none"> STEEL, CMPSN 1060 THRU 1080, ASTM A322. (A) FINISH ¹²⁵✓. FINISH 5.3.1.2 OF MIL-STD-171. MAY BE PURCHASED FROM LOCK RINGS, INC. 1302 NO. CONANT ST. MAUMEE, OHIO 43537. MIL-W-13855 APPLIES. (A) 																																																																													
																																																																													
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AMSWE Form 403B, 29 Jul 69

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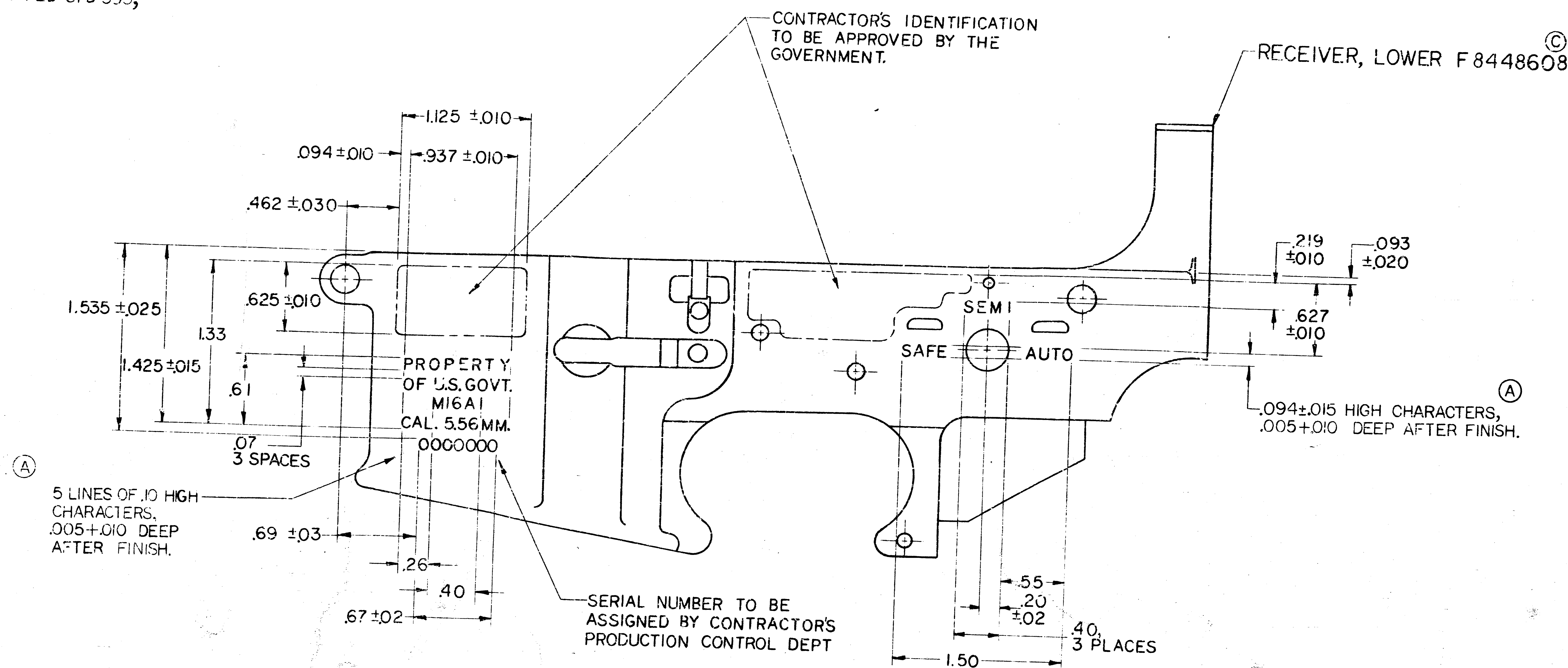
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NOTE:

1. GRIT BLAST BEFORE FINISH TO PRODUCE NON-REFLECTIVE MATTE SURFACE AFTER FINAL FINISH.
2. FINISH MIL-A-8625, TYPE III, CLASS 2. FILM THICKNESS .0010 ± .0002. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 3038, TABLE IX BUT NOT LIGHTER THAN GRA. NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL.
3. MIL-W-13855 APPLIES. (A)

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
	REDRAWN FROM COLT'S DRAWING D62222 REV C	27 APR 70	
A	(3) SEE ERR HQR 10626	20 FEB 71	
B	SEE ERR HQR 20778	15 OCT 72	
C	SEE HQR 751 0012-0001	16 APR 75	
D	100H230056	20 OCT 75	



SEE PL 8448580

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES		CONTRACT NO.	
YS		ANGLES ±		DATE 27 APR 1970	
MIN		3 PLACE DECIMALS ±.005		PREPARED BY [Signature]	
YS		2 PLACE DECIMALS ±.01		CHECKED BY [Signature]	
MAX		MATERIAL		ENGINEER [Signature]	
EL2		MAKE FROM RECEIVER, LOWER F8448608		SUBMITTED BY [Signature]	
RA		NEXT ASSY USED ON		APPROVED [Signature]	
BH		APPLICATION		SEE NOTE 2	
RH		C8448579 M16A1		SIZE CODE IDENT NO DRAWING NO.	
				D 19204 8448580	
				SCALE 2/1	

5	4	3	2	1																																			
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<p style="font-size: large; margin: 0;">(A)</p> <p style="font-size: large; margin: 0;">ALTERED ITEM DRAWING</p>			<p style="font-size: small; margin: 0;">CODE IDENT NO. 19200</p>																																				
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AMSWE Form 403B, 29 Jul 69

CDI

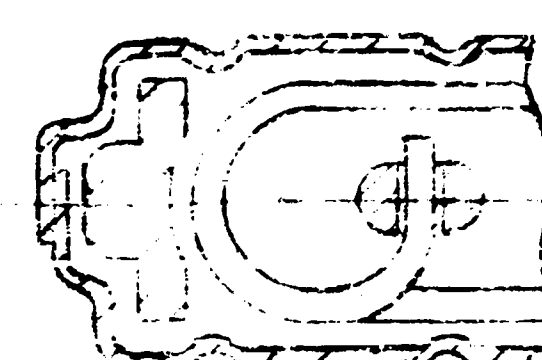
B8448664

NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

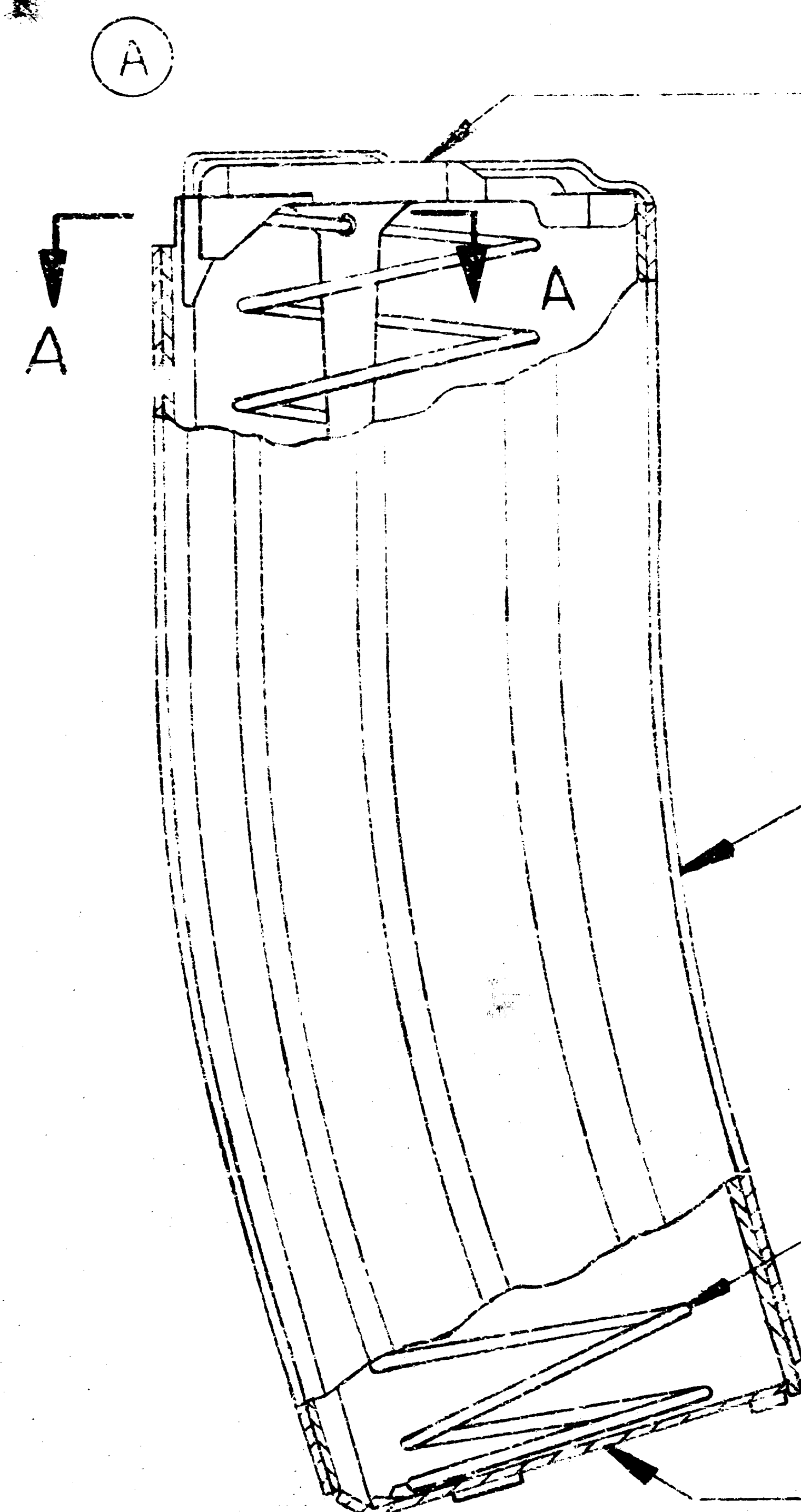
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NOTES:

1. MIL-H-13835 APPLIES.
2. SPRING FORCE WITH FOLLOWER DEPRESSED .250 INCH SHALL BE 3.0 LBS. \pm .5 LB. (B)
3. EACH MAGAZINE ASSEMBLY SHALL BE CAPABLE OF WITHSTANDING A 30 ROUND FUNCTION FIRING TEST WHEN FIRED IN THE M16A2 OR M16A1 (9349000 OR 8448500) UTILIZING THE BOLT CATCH CONFIGURATION OF DRAWING D8448628 REV A OR LATER, AND THE M231 FPW (9327045) UTILIZING THE BOLT CATCH CONFIGURATION OF DRAWING D9327059, WITHOUT MALFUNCTION, AFTER FIRING THE 30TH ROUND FROM THE MAGAZINE, THE MAGAZINE FOLLOWER SHALL ACTUATE THE WEAPONS BOLT CATCH TO HOLD THE BOLT IN THE OPEN POSITION.



SECTION A-A



FOLLOWER - 8448672

BOX - 8448674

SPRING - 8448671

PLATE - 8448673

SEE REF 8448670 (B)

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES	
MIN		ANGLES	
YS		3 PLACE DECIMALS \pm	
MAX		2 PLACE DECIMALS \pm	
EL 2			
RA			
BH			
RH			
	9349000 M16A2		
	9327045 M231 FPW		
	8448500 M16		
	8448600 M16A1		
	NEXT ASSY USED ON		
	APPLICATION		

DATE 5 JUN 70
 PREPARED: E.R. Indquist R. Passig
 CHECKED: J. Barclay J. D. Matthews
 ENGINEER: D. B. Hillier J. K. Holak
 SUBMITTED: J. P. Wilhoit
 APPROVED: R. S. Henry

CURRENT DESIGN ACTIVITY FSCM NO. 19203
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
 DOVER, NEW JERSEY 07801

FOR THE ARMY
 U.S. ARMY WEAPONS COMMAND
 ROCK ISLAND, ILLINOIS, 61901

MAGAZINE ASSY,
 30 ROUND

SIZE	CODE	ITEM NO	DRAWING NO
C	19204		8448670
SCALE	1/1		

DRAWING SIZE D

8

7

6

5

4

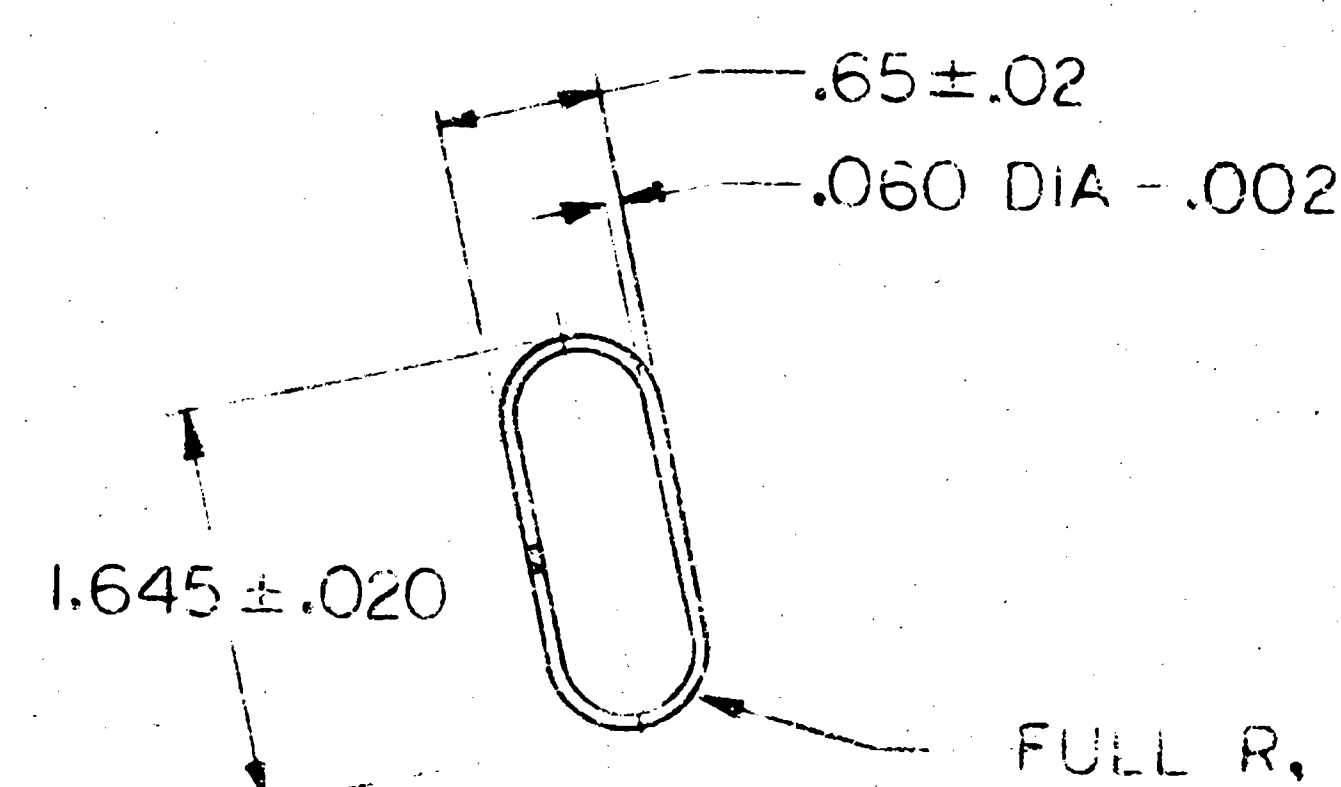
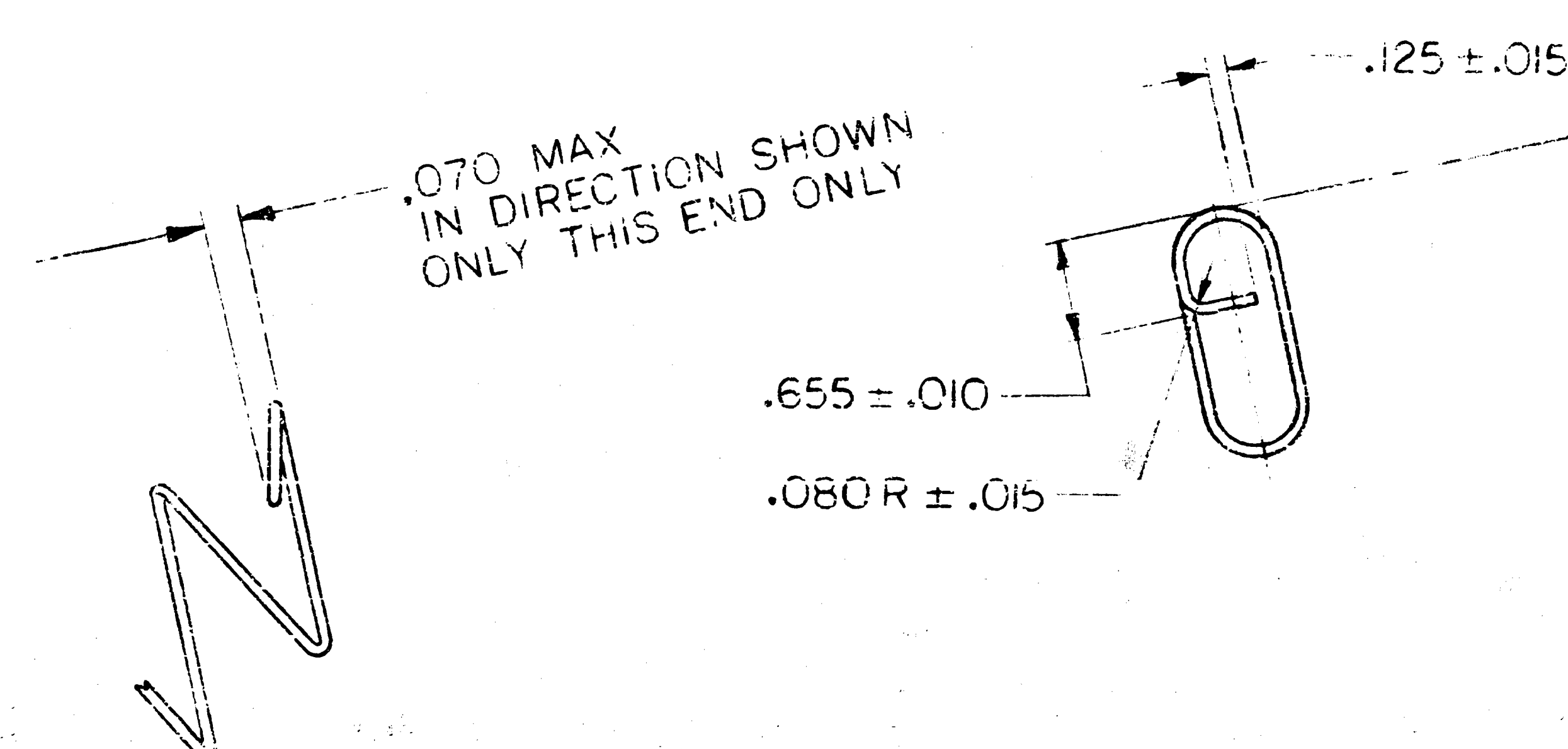
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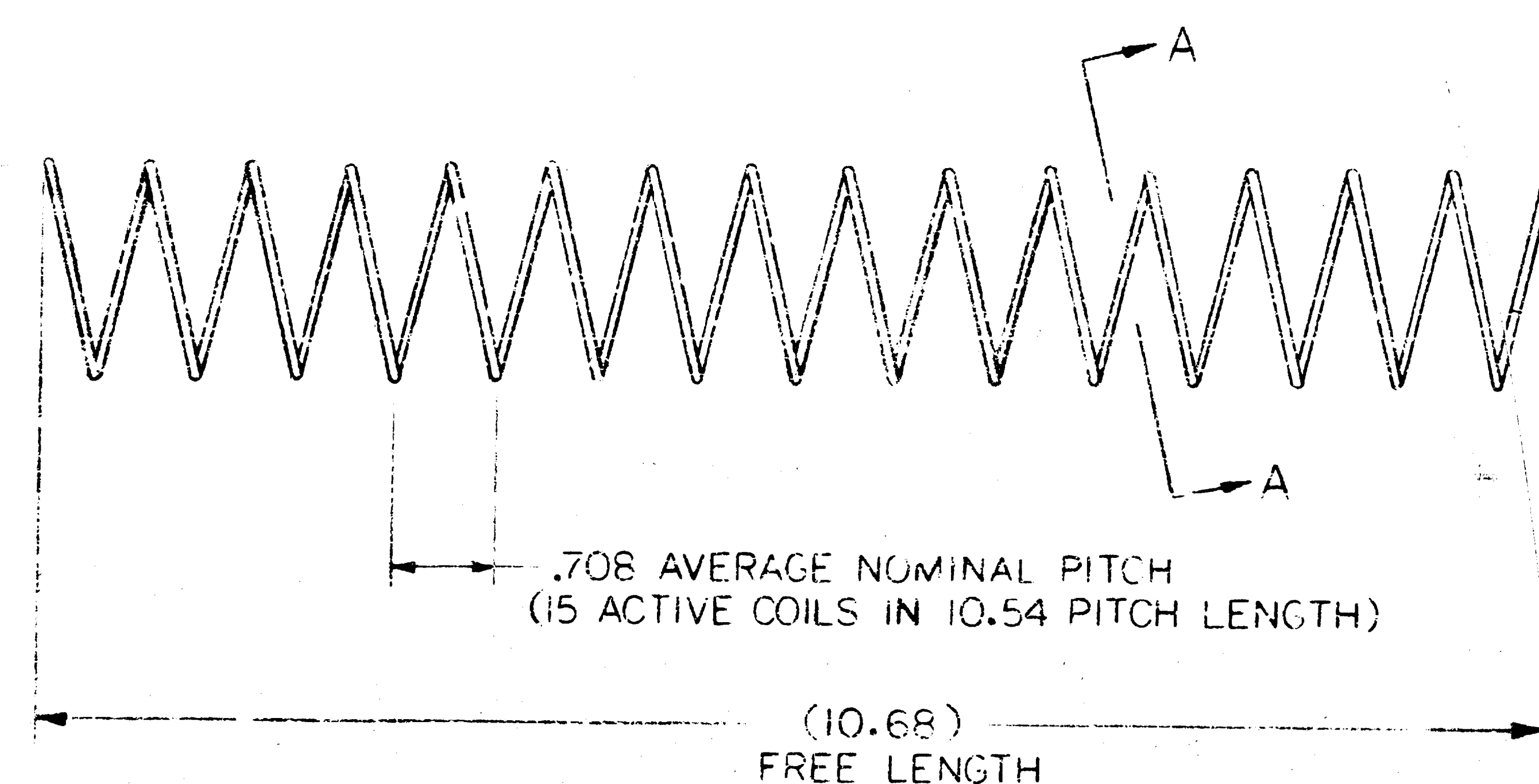
NOTES

1. MATERIAL: WIRE, STAINLESS STEEL, TYPE 316 (17-7PH)
2. FINISH: 125
3. FINAL PROTECTIVE FINISH: FINISH 5.4.1 OF MIL-STD-171
4. HEAT TREAT PER MIL-H-6875 EXCEPT AGING OPTIONAL
5. MIL-W-13805 APPLIES
6. LOAD HEIGHT REQUIREMENTS
 LOAD AT 5.565" = 3.1 LB. \pm 4 LB.
 LOAD AT 1.500" = 6.3 LB. \pm 7 LB.
 SET SPRING TO SOLID HEIGHT THREE TIMES BEFORE MEASURING LOADS.



SECTION A-A

FULL R, TYP IN TRUE HELICAL FORM CONTINUOUS HELIX WITH NO DWELL OR DIP-BACK.



PERMISSIBLE TWIST
30° THRU OVERALL
LENGTH

CURRENT DESIGN 8071-1-10-10
ARMAMENT RESEARCH DEVELOPMENT CENTER
PICATINNY ARSENAL, NEW HAMPSHIRE 03304

PART NO.

ROCK ISLAND ARSENAL
ROCK ISLAND, ILL 61651

CONTRACTOR
DATE
CHECKED
DATE

D 19204

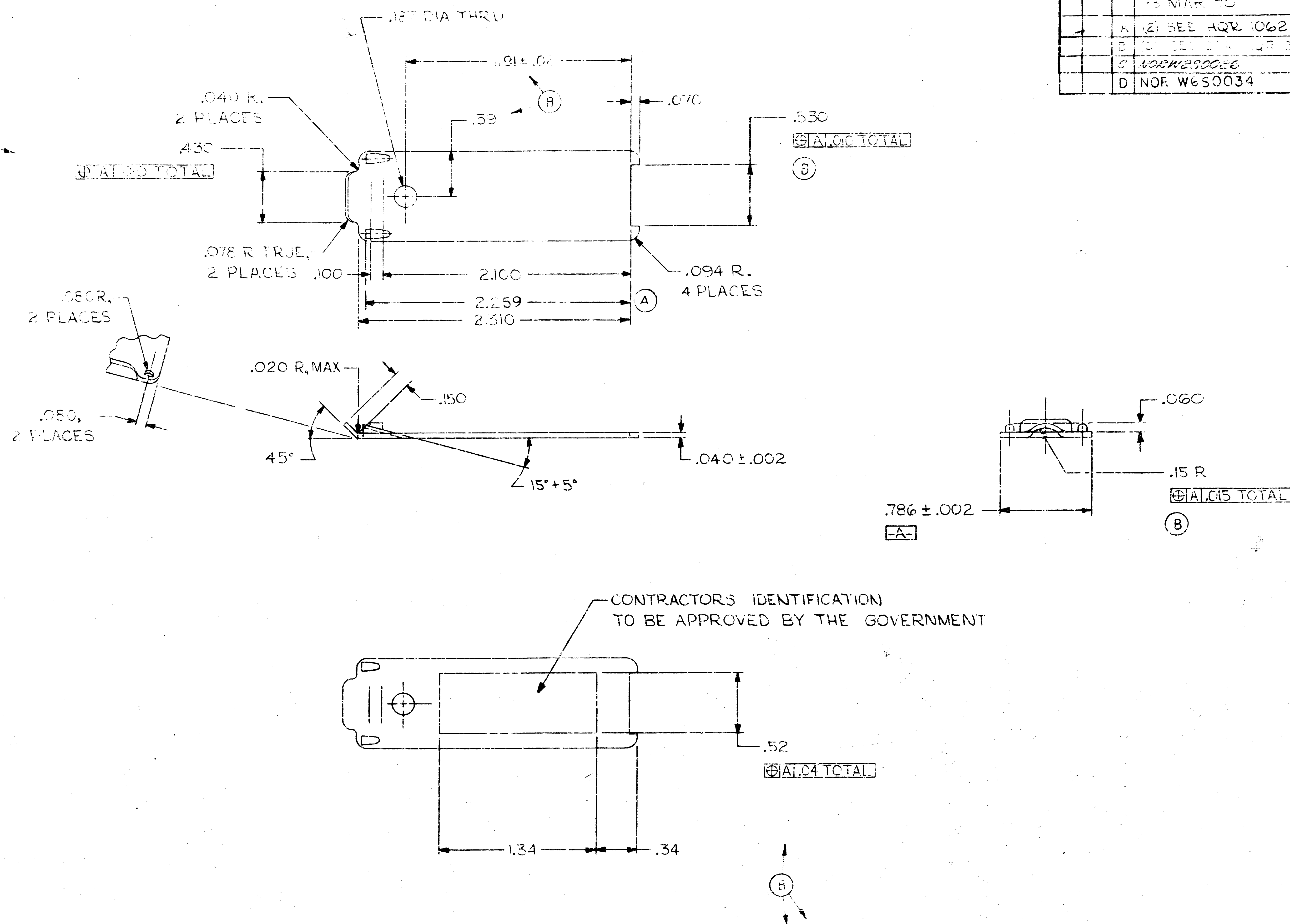
SMCAR FORM 68, 1 DEC 87(TEMP) REPLACES SMCAR FORM 68, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED.

PMIC		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS 2 PL. & .01 3 PL. & .01	CONTRACT NUMBER	
MECHANICAL PROPERTIES		THIRD ANGLE PROJECTION	DATE	
YP				
TS				
EL				
RA				
BH	30 ROUNDS			
RM	MAGAZINE			
	NEXT ASSY	USED ON		
	APPLICATION			

1

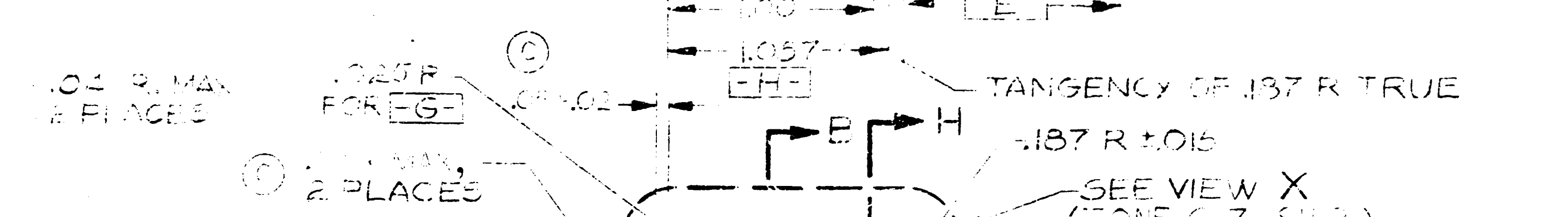
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REVISONS					DATE	APPROVED
MF	ZONE	LTR	DESCRIPTION			
			REDRAWN FROM COLT'S DRAWING D02008. DATED 23 MAR 70			
		A	2. SEE AQR 10622	11-25-71	W. H. H. H.	
		B	1. SEE AQR 10622	27-2-73	W. H. H. H.	
		C	1. NORM 200026	22-05-81	W. H. H. H.	
		D	NOR W650034	86 03 25	870204	

[illegible]

-CONTRACTORS IDENTIFICATION
TO BE APPROVED BY THE GOVERNMENT

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY US ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MIN				1 ANGLES ± .005 2 PLACE DECIMALS ± .005		DATE 5 JUN 78		PLATE, BOTTOM,	
YC MAX				2 PLACE DECIMALS ± .001		PREPARED P. Wilson & Assoc		MAGAZINE	
EL2				MATERIAL		CHECKED J. B. [Signature]			
RA				SEE NOTE 1		ENGINEER D. H. [Signature]			
BH		NO ROUNDING				SUBMITTED J. W. [Signature]			
RH		8448670-10-11F		FINAL PROTECTIVE FINISH		APPROVED J. [Signature]		SIZE CODE IDENT NO DRAWING NO	
		NEAT ASSY USED ON		APPLICATION SEE NOTE		D 19204		8448673	
		APPLICATION				SCALE		SHEET OF	

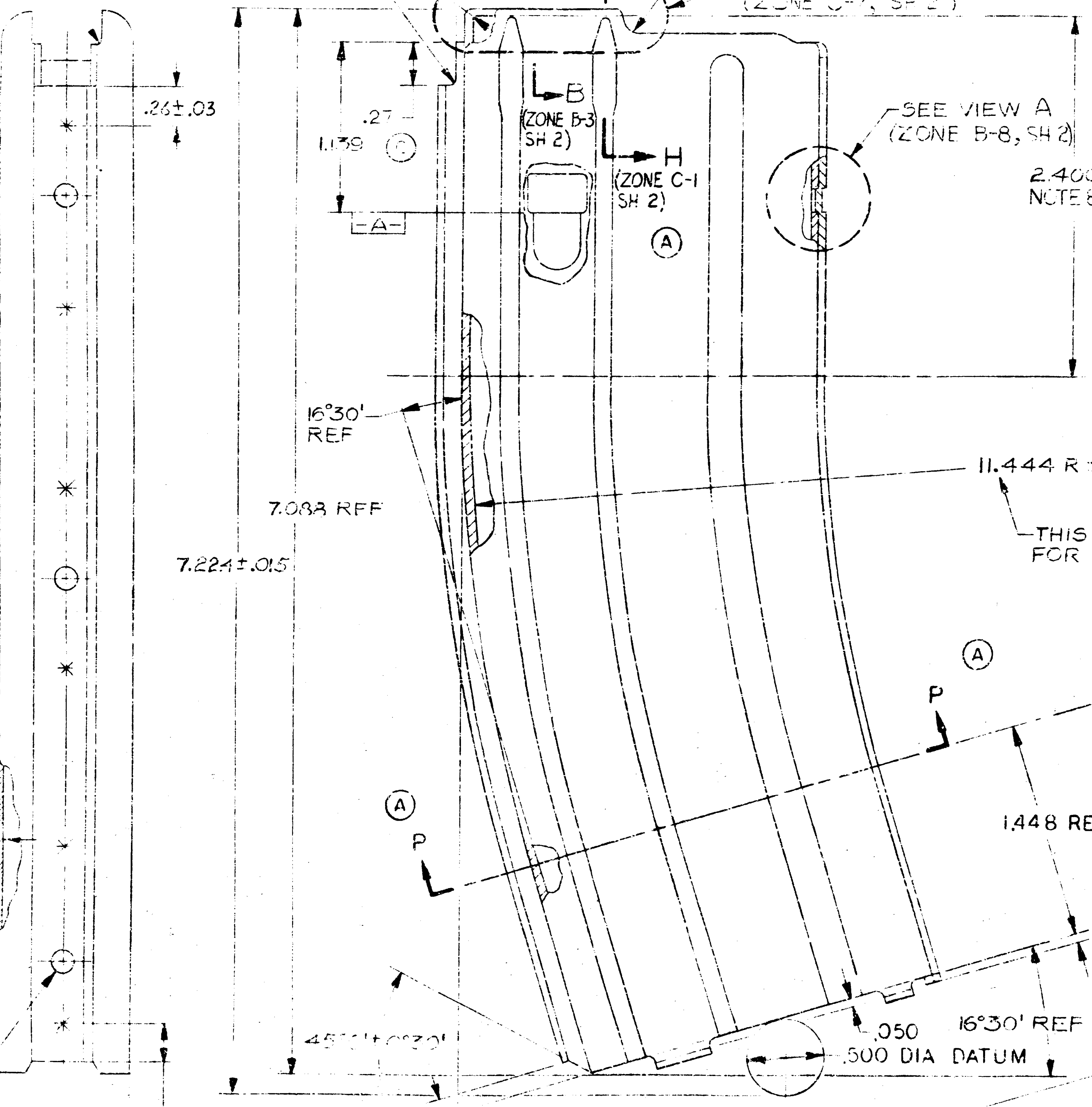
[illegible]

HEAT TREAT TO TEMPER T. PER AMS2770,
PARA 3.2.8.5.2 EXCEPT AGING TIME AND
TEMPERATURE ARE OPTIONAL. SEE NOTE
6. QUENCHANT TEMPERATURE SHALL START
AT 115°F OR LESS AND RISE TO A 135°F
MAXIMUM. MINIMUM BRINELL 80 (30MM BALL
500KS LOAD) OR EQUIVALENT (BARCOL 76 MINIMUM).

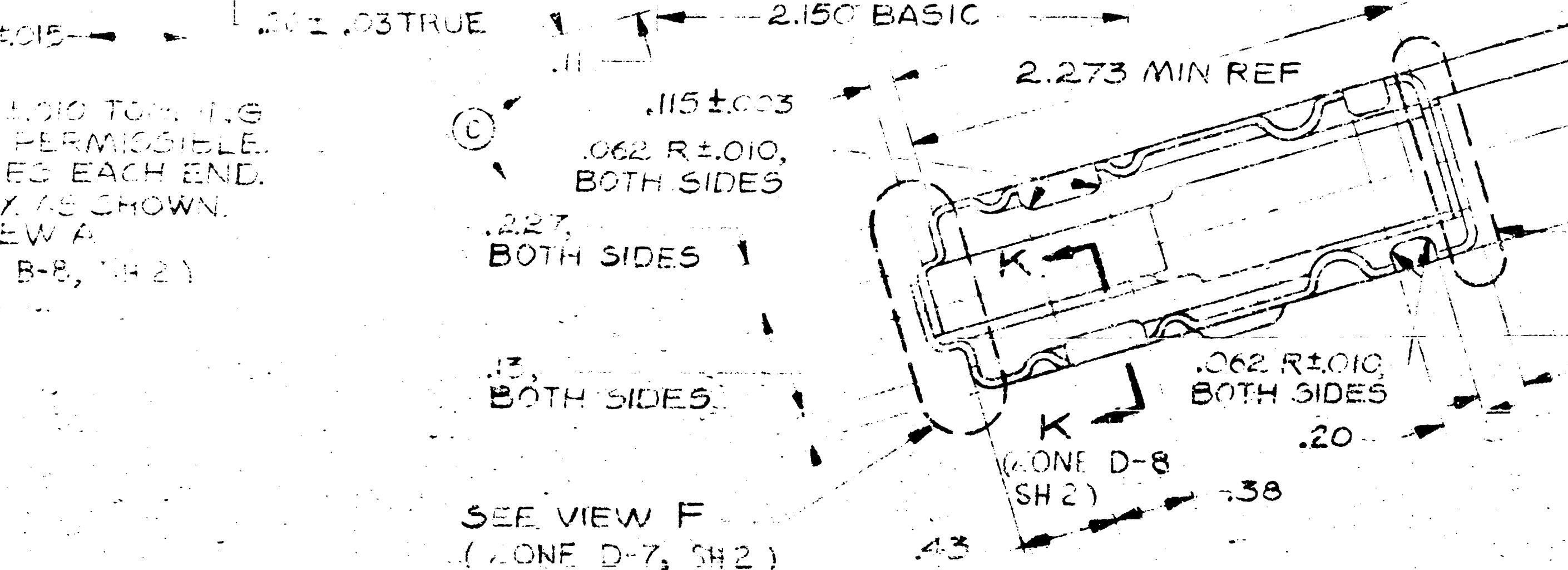
OR MIL-L-6619, FILM THICKNESS
0.0025 TO 0.0034. CAUTION: THE
SOLVENTS OF MIL-L-6619 ARE
CONTAMINATED WITH THE FOLLOWING
HARMFUL TOXIC AND/OR FLAMMABLE
COMPONENTS. THE COMPONENT HAS BEEN
IDENTIFIED FROM THE HAZARD TO
APPLICATIONS OF MIL-L-6619.

7-SPOT WELD TWELVE SPACES, PER MIL-W-4822. SIX WELDS, EQUALLY SPACED TO $\pm .03$, BOTH ENDS EXCEPT WELD BUTION DIAMETER SHALL BE 10 MIN. EACH WELD SHALL SUPPORT A STATIC COMPRESSIVE LOAD OF 100 LBS. APPLIED WITHIN LENGTH OF $\frac{1}{2}$ OPPOSITE FACE WELD IN THE DIRECTION OF FMT.

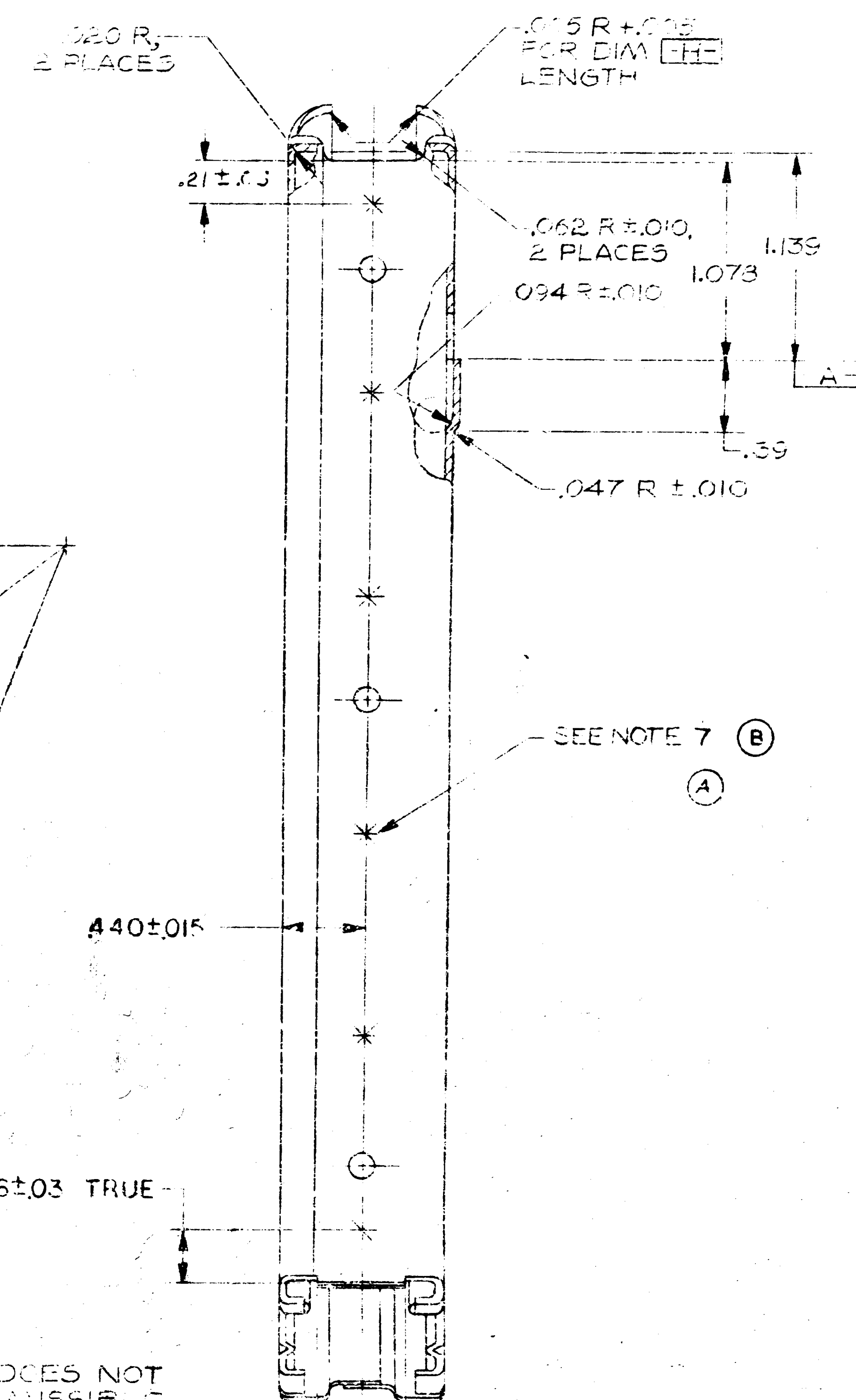
9. - MIL-W-13855 APPLIES.



44-15015-
 1000 1010 TON, 11G
 1110 PERMISSIBLE
 2. PLACES EACH END
 APPROX 45 CROWN.
 SEE VIEW A
 (ZONE B-8, 10-2)



- THIS DIMENSION DOES NOT
INCLUDE THE PERMISSIBLE
.005 OUT OF SQUARE
CONDITION IN SECTION P-P (A)
(ZONE B-i, SH 2)



(ZONE B-4
SHEET 2)

REVISION		DESCRIPTION	DATE	APPROVED
REDRAWN FROM CELT				
DRAWING J62637				
A	(6)	EE ERR HQR 106211	13 JUL 7	8 B
B	(3)	SEE ERR HQR 108111	13 JUL 7	8 B
C	(1)	SEE ERR HQR 30713	13 JUL 7	8 B
D	(1)	SEE ERR HQR 30713	13 JUL 7	8 B
E	(1)	SEE ERR HQR 30713	13 JUL 7	8 B
F	(1)	SEE ERR HQR 30713	13 JUL 7	8 B
G	(1)	SEE ERR HQR 30713	13 JUL 7	8 B
H	(1)	SEE ERR HQR 30713	13 JUL 7	8 B
I	(1)	SEE ERR HQR 30713	13 JUL 7	8 B
J	(1)	SEE ERR HQR 30713	13 JUL 7	8 B
K	(1)	SEE ERR HQR 30713	13 JUL 7	8 B

K	K
SH 1	SH 2
REV STATUS OF SHEETS	

[illegible]

[illegible]

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES		DEPARTMENT OF THE ARMY	
		TOLERANCES		US ARMY WEAPONS COMMAND	
FVS		ANGLES		ROCK ISLAND, ILLINOIS, 6120	
M-H-N		3 PLACE DECIMALS ±			
MAX		3 PLACE DECIMALS ±		DATE	
EL-2		SHEET		DRAWN BY: <i>W. J. Taylor</i>	
BA				CHECKED BY: <i>W. J. Taylor</i>	
BH				APPROVED BY: <i>W. J. Taylor</i>	
BH		NEXT ASSY USED CN		F 19204 8448674	
APPLICATION		FINAL PROTECTIVE FINISH		APPROVED BY: <i>W. J. Taylor</i>	

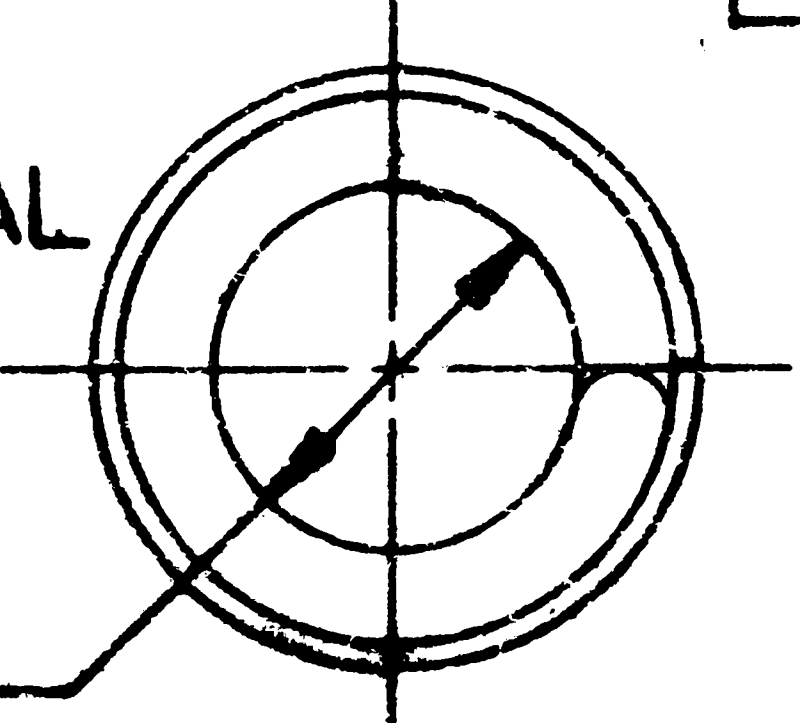
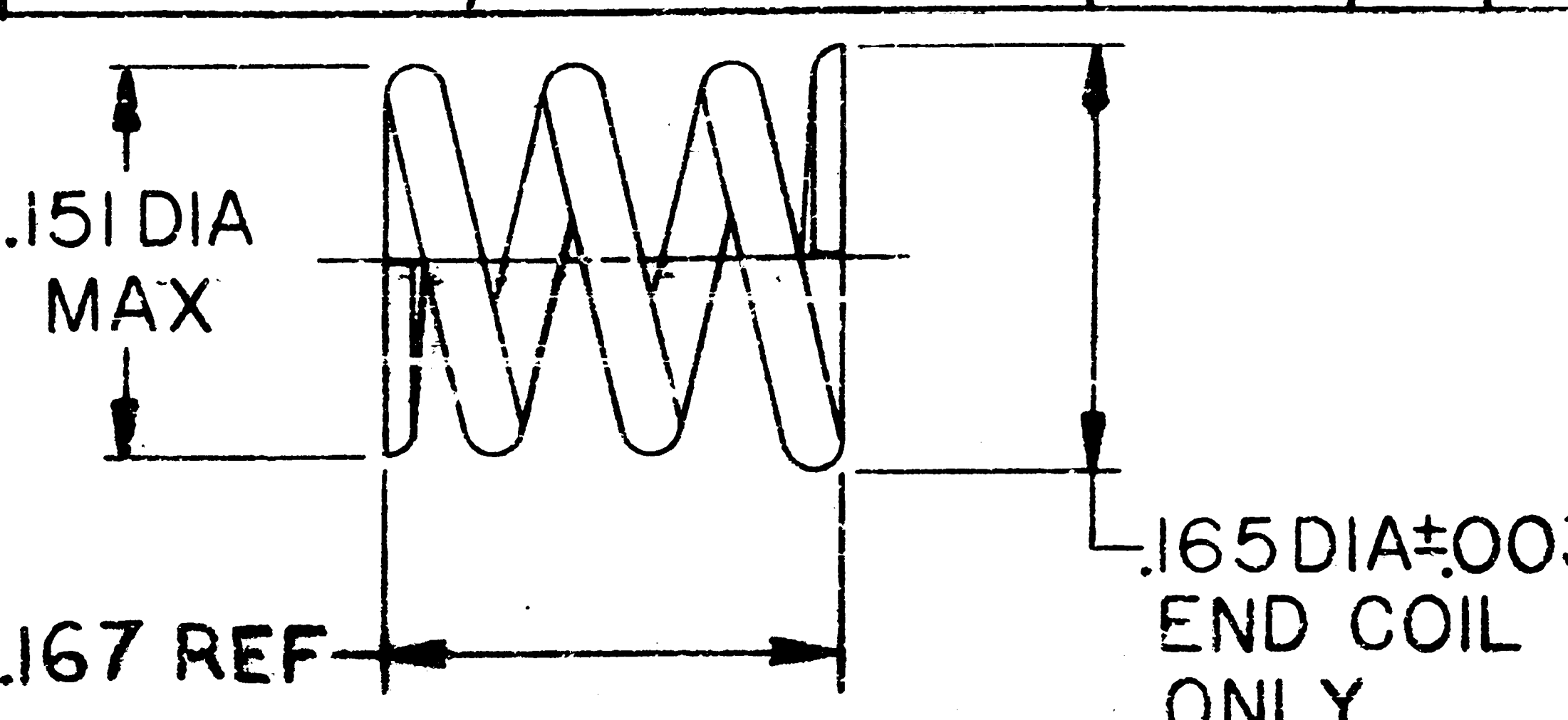
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SAME AS MS16535-125 EXCEPT
FINAL PROTECTIVE FINISH TO BE
5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.

ALTERED ITEM DRAWING
PART NO. 8448697

MECHANICAL PROPERTIES		8448300		M203		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		PART NO. 8448697	
YS MIN		C8448565		M16		TOLERANCES:		DATE 11 APR 72		DEPT OF THE ARMY	
YS MAX				M16A1		ANGLES ±		PREP R. May		US ARMY WEAPONS COMMAND	
EL 2		D8448663		M16		3 PLACE DECIMALS ±		CHK R. Holst		ROCK ISLAND, ILLINOIS, 61201	
RA				M16A1		2 PLACE DECIMALS ±		ENGR D. B. Billitt R. E. E. B.		RIVET	
BH						MATERIAL		SUBMITTED		SIZE CODE IDENT NO DRAWING NO.	
RH		NEXT ASSY		USED ON		FINAL PROTECTIVE FINISH		APPROVED		B 19204 8448697	
		APPLICATION				SEE NOTE		Loren F. Brunton		SCALE NONE SHEET 1 OF 1	

EDITION OF 29 JUL 69 MAY BE USED.

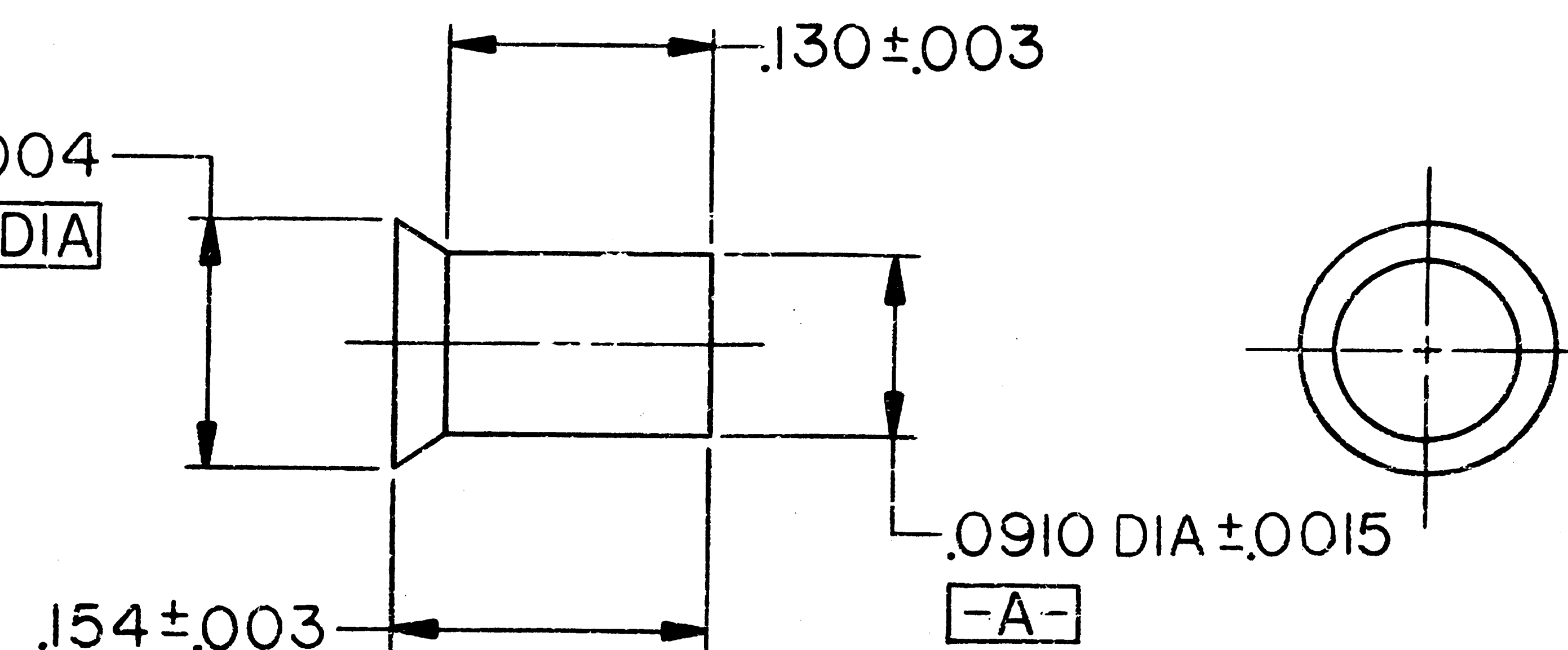
5	4	3	2	1																																						
E NOR G852005/880310 880927			REVISIONS																																							
<p>NOTES:</p> <p>1. WIRE, STEEL, MUSIC SPRING QUALITY PER ASTM-A228 TABLE I .022 SIZE EXCEPT TENSILE STRENGTH TO BE 363,000 TO 393,000 PSI.</p> <p>2. STRESS RELIEVE-HOLD AT 450°F±25°F FOR 30 MIN.</p> <p>3. SUGGESTED SOURCE OF SUPPLY: NATIONAL STANDARD, NILES, MICHIGAN 49120; MAPES PIANO STRING CO., ELIZABETH, TENN. 37644; JOHNSON WIRE & STEEL, WORCESTER, MASS.</p> <p>4. MANUFACTURE IN ACCORDANCE .100 MIN WITH TYPE I, GRADE A, MIL-S-13572.</p> <p>5. MIL-W-13855 APPLIES (A)</p> <p>6. BREAK SHARP EDGES .003*.012</p>			MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED																																		
			M		A	SEE ERR HQR 20778	6 OCT 72	<i>[Signature]</i>																																		
			M		B	NOR W9S2009 80-02-13	80-05-16	<i>[Signature]</i>																																		
					C	NOR W2S0011 / 82-04-13 (ECP W3S3120 / 83-07-07)	83-11-04	<i>[Signature]</i>																																		
					D	NOR W6S3014 / 86-03-25 ECP W6S0106 / 86-10-09	87-02-17	<i>[Signature]</i>																																		
						<p>NOTES: CONTINUED</p> <p>*7. PRESET-COMPRESS TO SOLID HEIGHT 3 TIMES PRIOR TO CHECKING LOADS.</p>																																				
SPRING DATA			<p>DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201</p> <p style="text-align: center;">SPRING, EXTRACTOR</p>																																							
WIRE DIA .0220																																										
TOTAL COILS 4 REF																																										
DIRECTION OF HELIX OPTIONAL																																										
* LOAD AT COMPRESSED LENGTH OF .140 IN = 2.0 LB ± 0.2 LB																																										
* LOAD AT COMPRESSED LENGTH OF .112 IN = 4.2 LB ± 0.4 LB																																										
ONE END EXPANDED TO DIM. (C)			<p style="text-align: center;">PART NO. 8448753</p>																																							
TYPE OF ENDS CLOSED AND GROUND																																										
SOLID LENGTH .090 MAX																																										
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2">MECHANICAL PROPERTIES</th> <th colspan="2">UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</th> </tr> </thead> <tbody> <tr> <td>YS MIN</td> <td></td> <td colspan="2">TOLERANCES:</td> </tr> <tr> <td>YS MAX</td> <td>B 11828591</td> <td colspan="2">ANGLES ±</td> </tr> <tr> <td>EL 2</td> <td>B 8448755</td> <td colspan="2">3 PLACE DECIMALS ± .005</td> </tr> <tr> <td>RA</td> <td></td> <td colspan="2">2 PLACE DECIMALS ±</td> </tr> <tr> <td>BH</td> <td></td> <td colspan="2">MATERIAL</td> </tr> <tr> <td>RH</td> <td></td> <td colspan="2">SEE NOTE 1</td> </tr> <tr> <td colspan="2">NEXT ASSY</td> <td colspan="2">USED ON</td> </tr> <tr> <td colspan="2">APPLICATION</td> <td colspan="2">FINAL PROTECTIVE FINISH</td> </tr> </tbody> </table>			MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		YS MIN		TOLERANCES:		YS MAX	B 11828591	ANGLES ±		EL 2	B 8448755	3 PLACE DECIMALS ± .005		RA		2 PLACE DECIMALS ±		BH		MATERIAL		RH		SEE NOTE 1		NEXT ASSY		USED ON		APPLICATION		FINAL PROTECTIVE FINISH		CONTRACT NO.		<p style="text-align: center;">DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201</p>	
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RH		SEE NOTE 1																																								
NEXT ASSY		USED ON																																								
APPLICATION		FINAL PROTECTIVE FINISH																																								
		DATE 4 NOV 71																																								
		PREP <i>[Signature]</i>																																								
		CHK <i>[Signature]</i>																																								
		ENGR <i>[Signature]</i>																																								
		SUBMITTED <i>[Signature]</i>																																								
		APPROVED <i>[Signature]</i>		<p>SIZE B CODE IDENT NO. 19204 DRAWING NO. 8448753</p> <p>SCALE 10/1 SHEET 1 OF 1</p>																																						

NOTES:

1. RUBBER, FLUOROSILICONE, TYPE II, CLASS I, GRADE 60, SPEC MIL-R-25988 EXCEPT: TABLE II, AGING IN STAUFFER BLEND 7700 FLUID, COMPRESSION SET REQUIREMENTS SHALL NOT APPLY.
2. ALL EXTERIOR AND INTERIOR EDGES TO BE .005 R MAX.
3. MIL-W-13855 APPLIES.

(A)

.125 DIA \pm .004
 Φ A .010 DIA



CURRENT DESIGN ACTIVITY
 ESCM NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
 DOVER, NEW JERSEY 07801

PART NO. 8448754

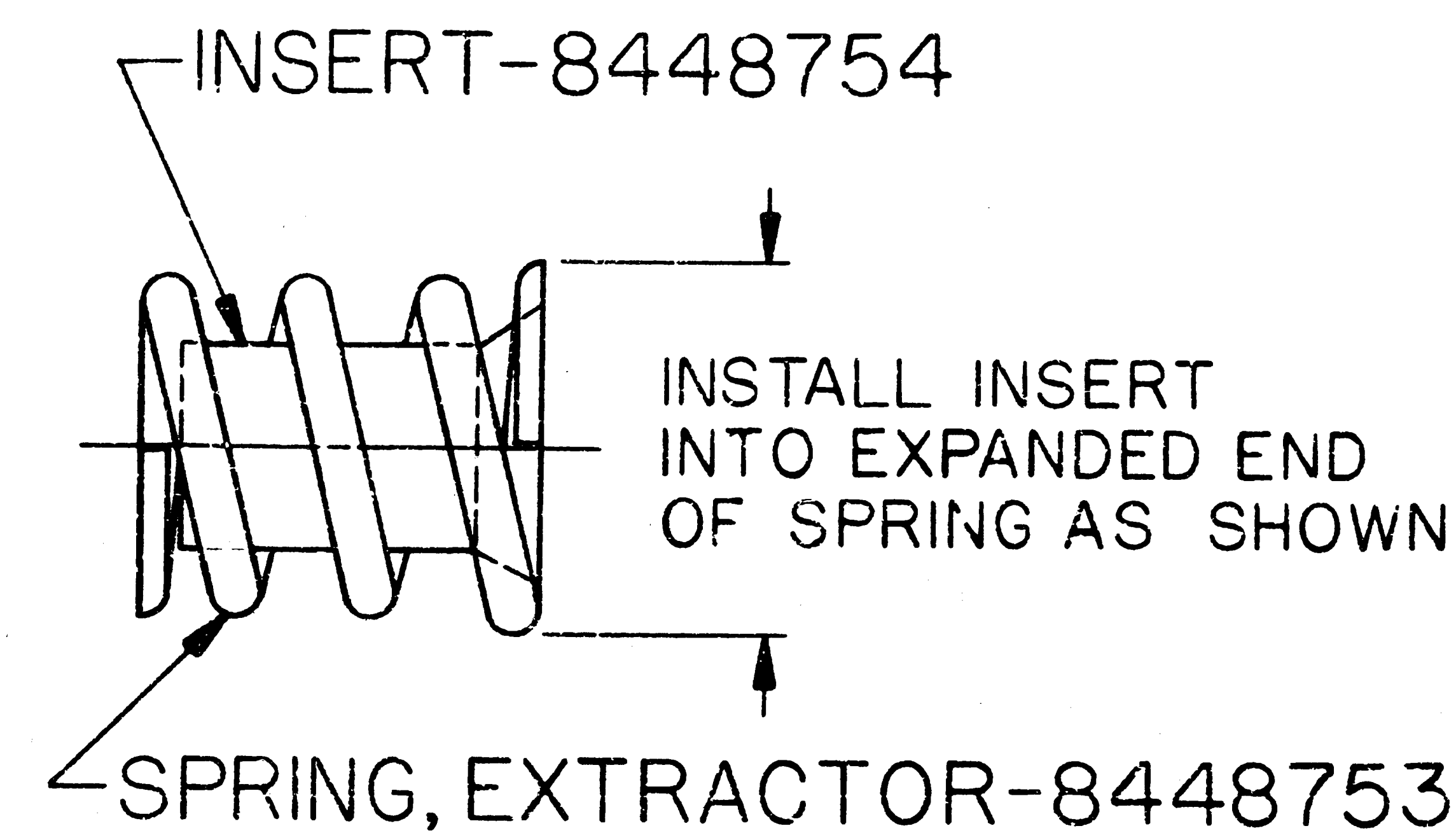
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY	
YS		TOLERANCES		DATE 4 NOV 71		U.S. ARMY WEAPONS COMMAND	
MIN		ANGLES		PREP		ROCK ISLAND, ILLINOIS, 61201	
YS		3 PLACE DECIMALS \pm —		CHK		INSERT, SPRING	
MAX		2 PLACE DECIMALS \pm —		ENGR		SIZE CODE IDENT NO. DRAWING NO.	
EL 2	B8448755	MATERIAL		SUBMITTED		B 19204 8448754	
RA		SEE NOTE 1		APPROVED		SCALE 10/1 SHEET 1 OF 1	
BH		NEXT ASSY USED ON		R. S. Henry			
RH		APPLICATION					
		FINAL PROTECTIVE FINISH					

AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

NOTE:
MIL-W-13855 APPLIES.

REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
	A		NORM 250026	82-05-21
				83-02-03
				84-03-16



CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

SEE PL 8448755

PART NO. 8448755

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO. 4 NOV 71		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MIN		TOLERANCES:		DATE		SPRING ASSY, EXTRACTOR	
YS MAX		ANGLES ±		PREP	T.A. Wilson		
EL 2		3 PLACE DECIMALS ±		CHK	S. Frutkin		
RA		2 PLACE DECIMALS ±		ENGR	R. S. Cole		
BH		C8448509	MIG	SUBMITTED			
RH			MIGAI	APPROVED	R. S. Heney		
		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH		SIZE	CODE IDENT NO.
		APPLICATION				B	19204
						DRAWING NO. 8448755	
						SCALE 10/1	SHEET 1 OF 1

AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

3

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NOTES:

1. GRIT BLAST AFTER ASSEMBLY AND PRIOR TO FINISH TO PRODUCE NON-REFLECTIVE MATTE FINISH.
2. MIL-W-13855 APPLIES.

COVER, EJECTION PORT-8448785

.030 MIN, 2 PLACES

.030 MAX, 2 PLACES

HOUSING, COVER LATCH-8448784
(NO RELATIVE MOVEMENT BETWEEN HOUSING AND COVER PERMISSIBLE AFTER SWAGING)

SWAGE 2 PLACES

.030 MIN, 2 PLACES

.193±.010, 2 PLACES

.12±.05, 2 PLACES

.005 R MIN,
4 PLACES.020 R MIN
4 PLACES

SEE PL-8448783

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES	
YS		ANGLES	±
MIN		3 PLACE DECIMALS	±
MAX		2 PLACE DECIMALS	±
EL 2			
RA			
BM			
RN			
D8448525 M 231		CONTRACT NO	
D8448525 MIS/MISA		DATE 15 SEPT 72	
NEXT ASSY USED ON		PREPARED BY [Signature]	
APPLICATION		CHECKED BY [Signature]	
		ENGINEER BY [Signature]	
		SUBMITTED BY [Signature]	
		APPROVED BY [Signature]	
		FINAL PROTECTIVE FINISH	
		5.3.1.2 OF MIL-STD-171	

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT

CODE IDENT NO

PART NO. 8448783

19200

U S ARMY
HEADQUARTERS
DOVER, NEW JERSEY

EJECTION PORT COVER AND
LATCH HOUSING ASSY

DATE 15 SEPT 72
D 8448783

SCALE 10/1

8

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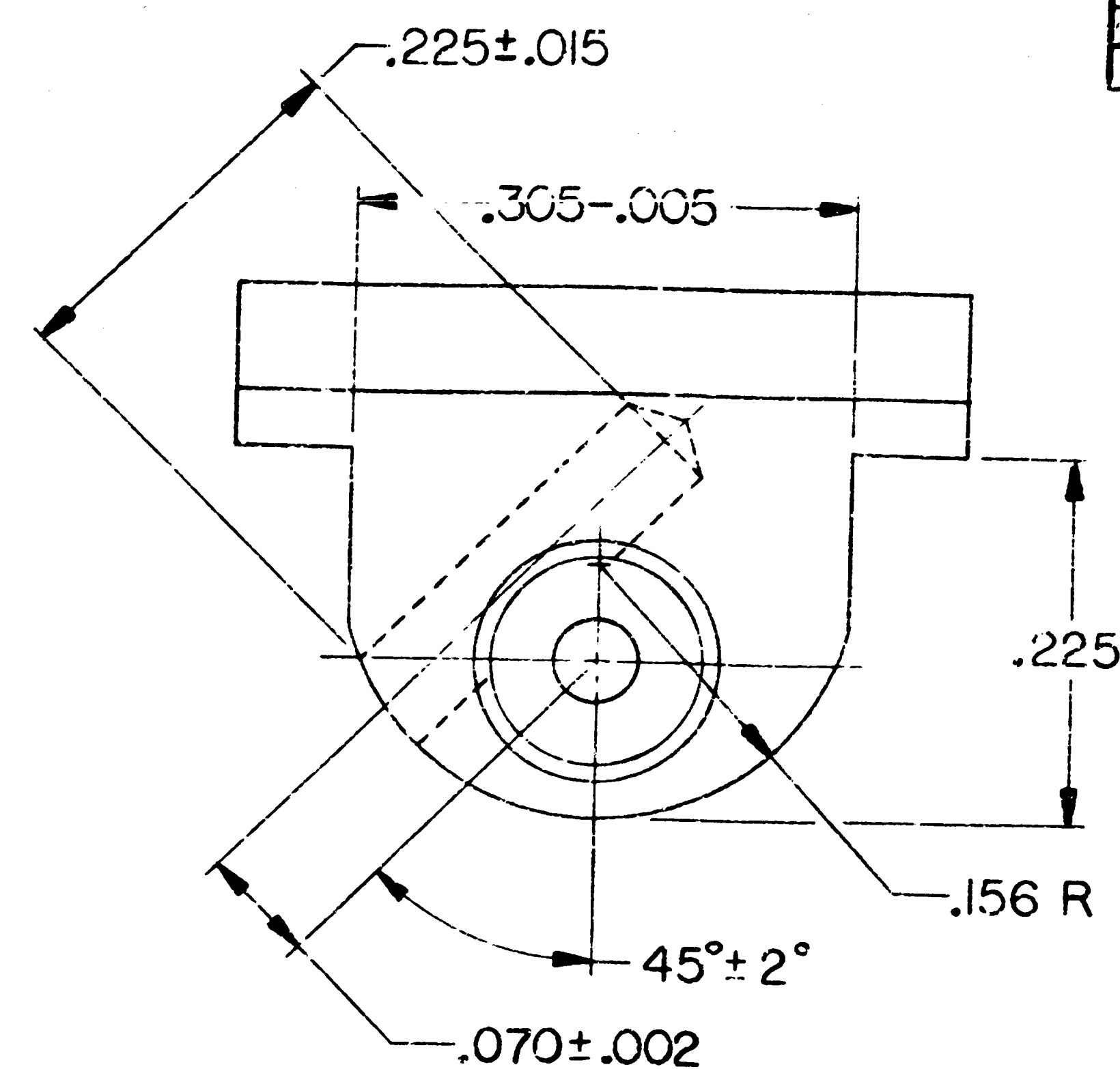
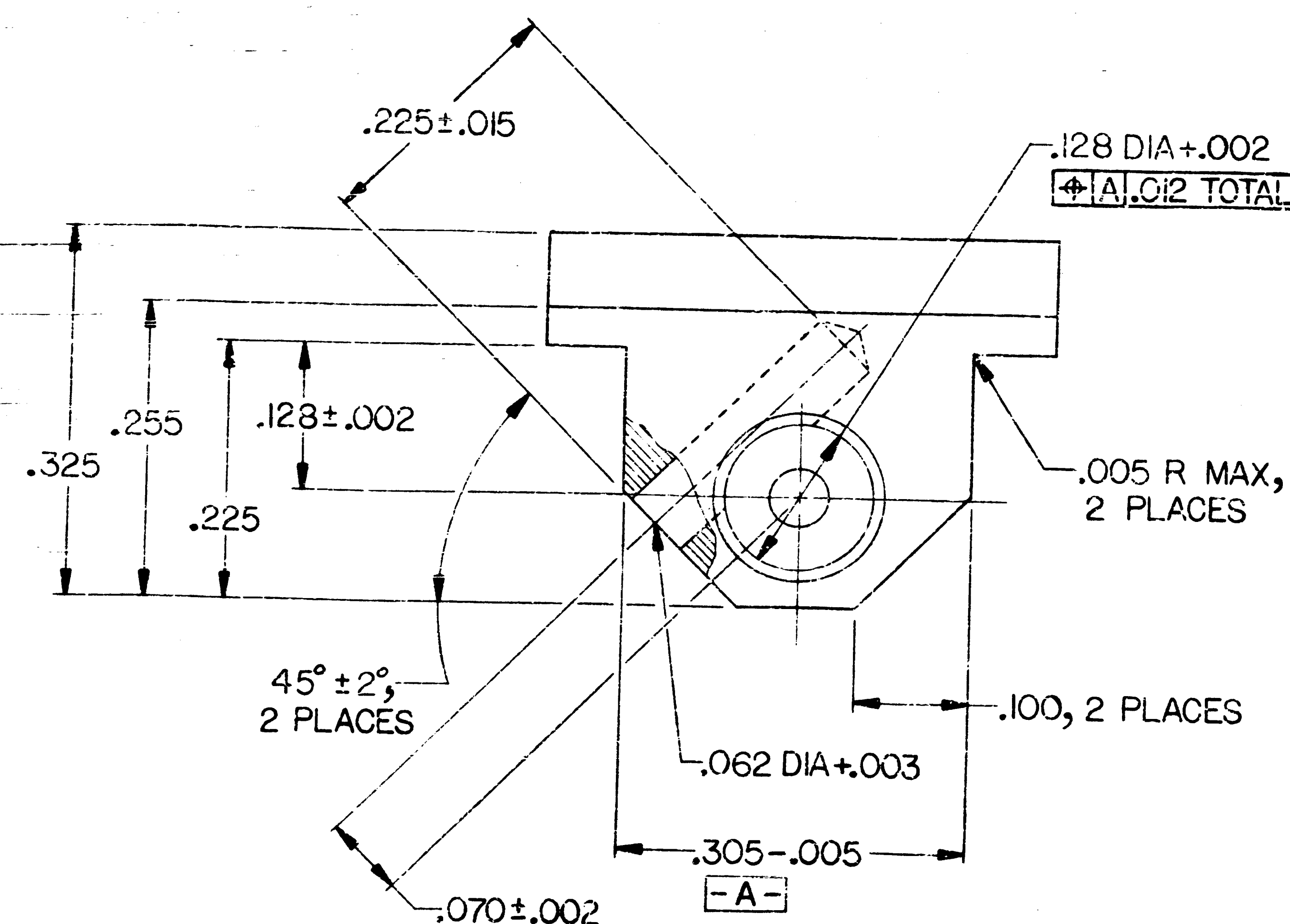
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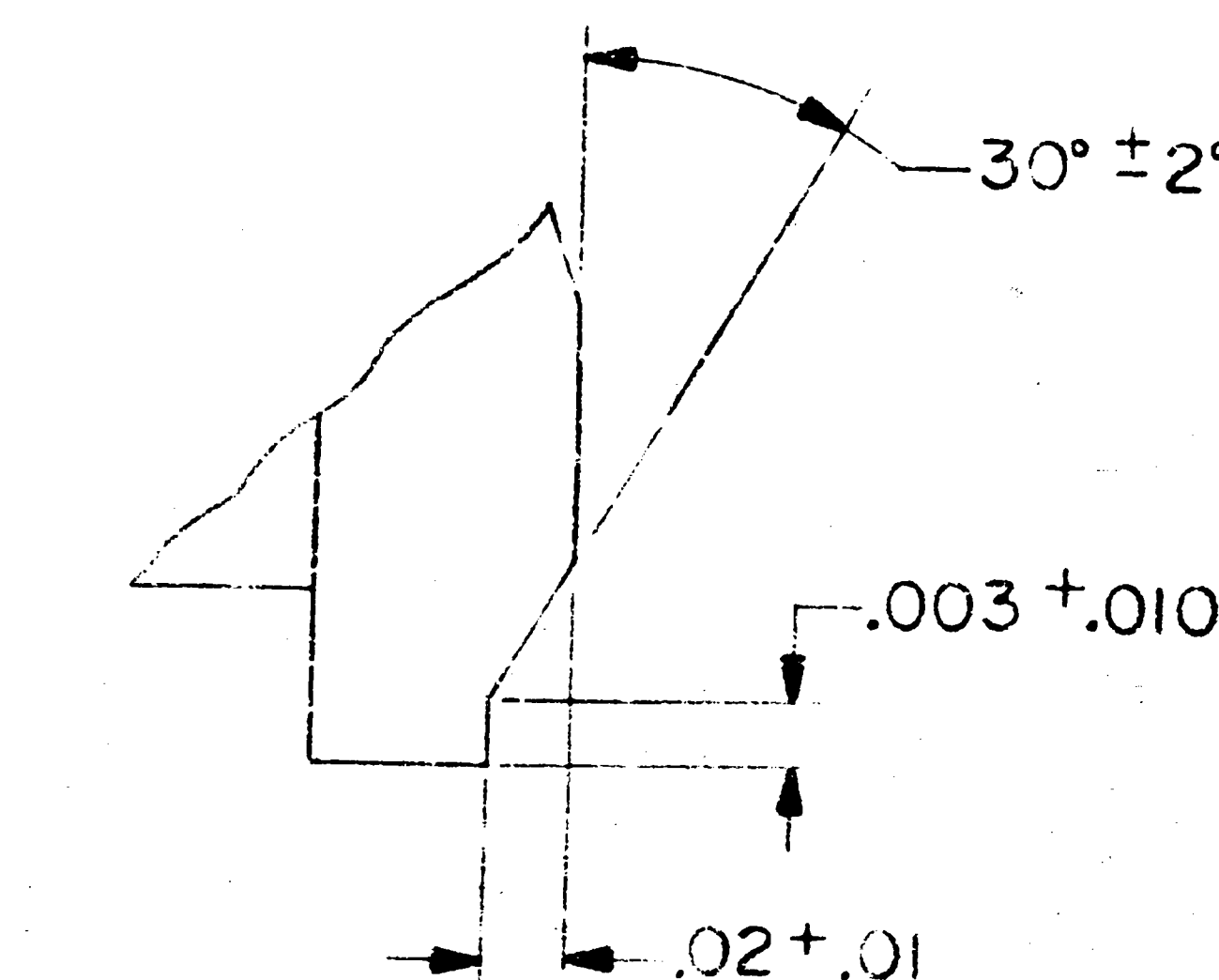
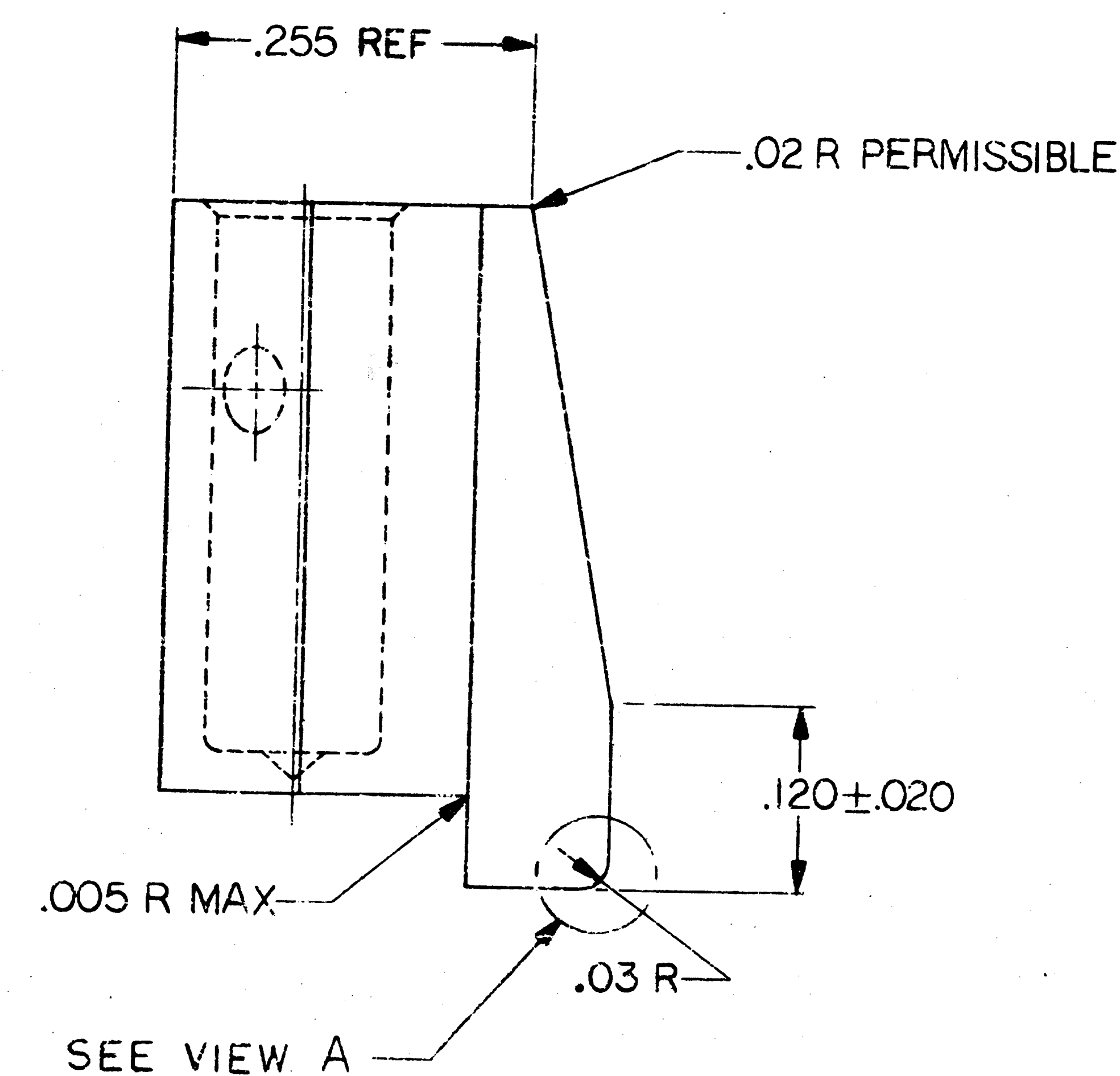
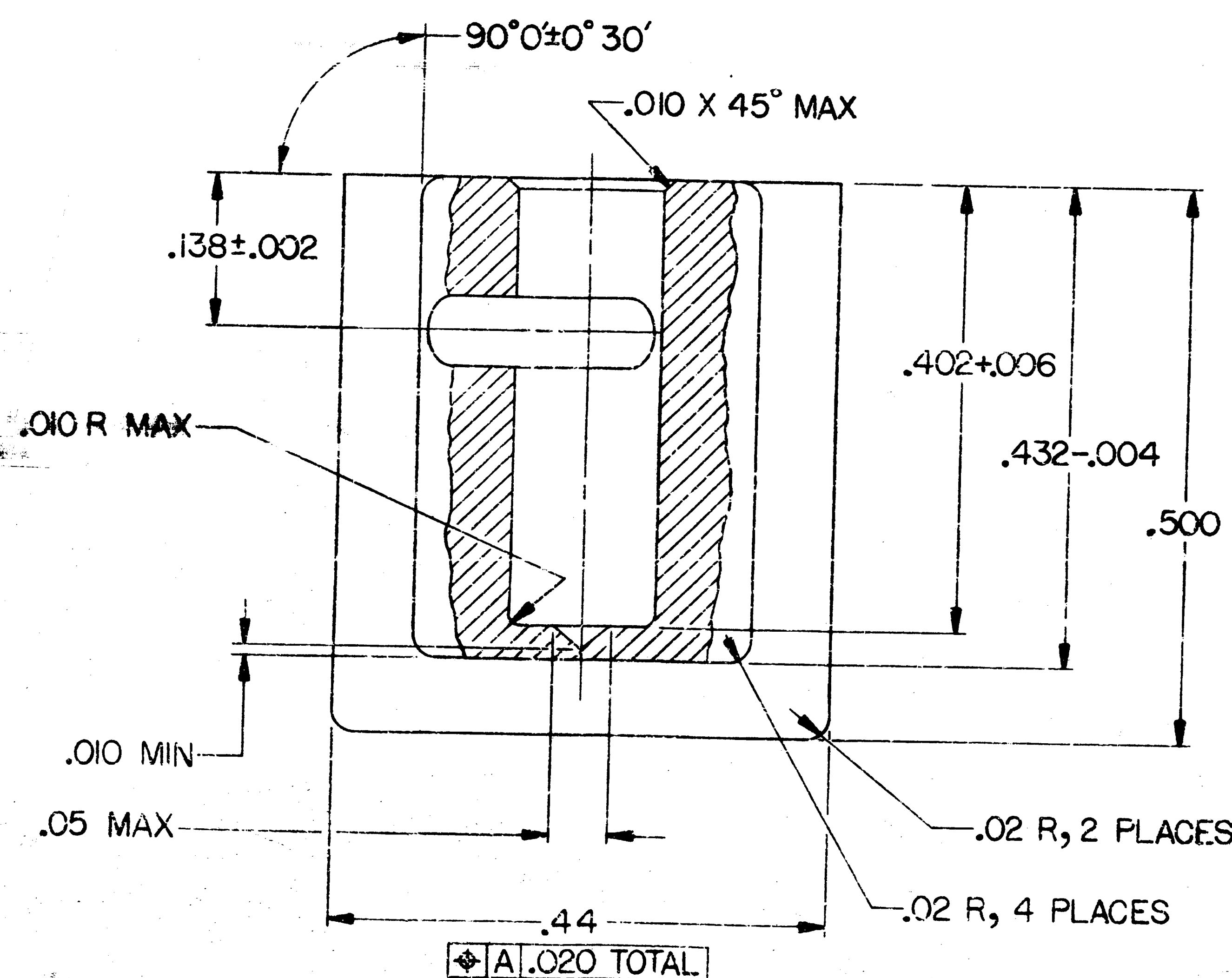
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NOTES:

1. STEEL, CMPSN 1018 TO 1022, SPEC ASTM A103; OR SINTERED STEEL, GRADE 1, CLASS A, DENSITY TYPE II PER ASTM B484-70. SINTERED MATL SHALL BE SEALED WITH POLYESTER RESIN.
2. FINISH $\sqrt{\text{V}}$.
3. BREAK ALL SHARP EDGES $.005 \pm .010$ EXCEPT AS NOTED.
4. MIL-W-13855 APPLIES.



ALTERNATIVE DESIGN

VIEW A
ALTERNATIVE CONFIGURATION
NOT TO SCALE

CURRENT DESIGN ACTIVITY FSCM No. 19200
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448784

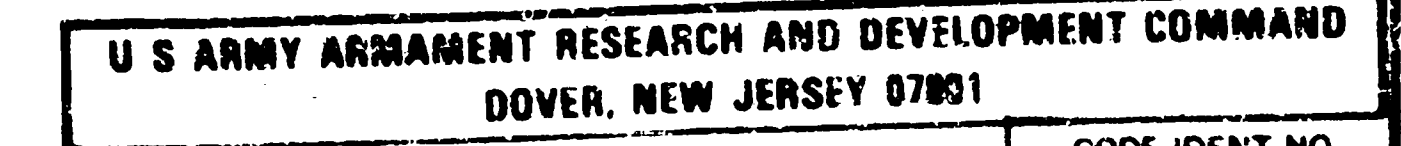
DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

HOUSING, COVER LATCH

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ANGLES: 2° 10° 3 PLACE DECIMALS: .005 2 PLACE DECIMALS: .01		CONTRACT NO.	
YS MIN		SEE NOTE 1		DATE	15 SEPT 72
YS MAX				PREPARED BY	Li Hong
EL 2				CHECKED BY	Brumby
KA				ENGINEER	Brumby
BH				SUBMITTED	Brumby
RH				APPROVED	R. J. Henry
D3448783		MIS/MISAI		SIZE CODE IDENT NO DRAWING NO	
NEXT ASSY USED ON		FINAL PROTECTIVE FINISH		D 19204 8448784	
APPLICATION				SCALE 10/1 SHEET 1 OF 1	

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1. STEEL, CMPSN 1045 TO 1055, ANNEALED, COLD ROLLED STRIP, NO 2 FINISH, SPEC QQ-S-700.
2. BREAK ALL SHARP EDGES .005R+.005.
3. HEAT TREATMENT: AUSTEMPER TO HARDNESS SPECIFIED.
4. MIL-W-13855 APPLIES.



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		PART NO.	
YS		TOLERANCES		DATE 15 SEPT 72		SEPT OF THE ARMY US ARMY RESEARCH COMMAND ROCK ISLAND, ILLINOIS, 61901	
MIN		ANGLES		PREPARED BY <i>T. J. J. J.</i> <i>P. J. J.</i>		COVER, EJECTION PORT	
MAX		3 PLACE DECIMALS ± .005		CHECKED BY <i>J. J. J.</i> <i>P. J. J.</i>			
ELZ		2 PLACE DECIMALS ± .01		ENGINEERED BY <i>J. J. J.</i> <i>P. J. J.</i>			
RA		MATERIAL		SUBMITTED			
BH		SEE NOTE 1		APPROVED BY <i>J. J. J.</i> <i>P. J. J.</i> <i>R. S. H.</i>		SIZE CODE IDENT NO DRAWING NO D 15204 8448785	
RH	C361042	08448525 M 231 08448783 M16/M16A1	FINAL PROTECTIVE FINISH			SCALE: 2/1 SHEET OF 1	
APPLICATION							

5 4 3 2 1

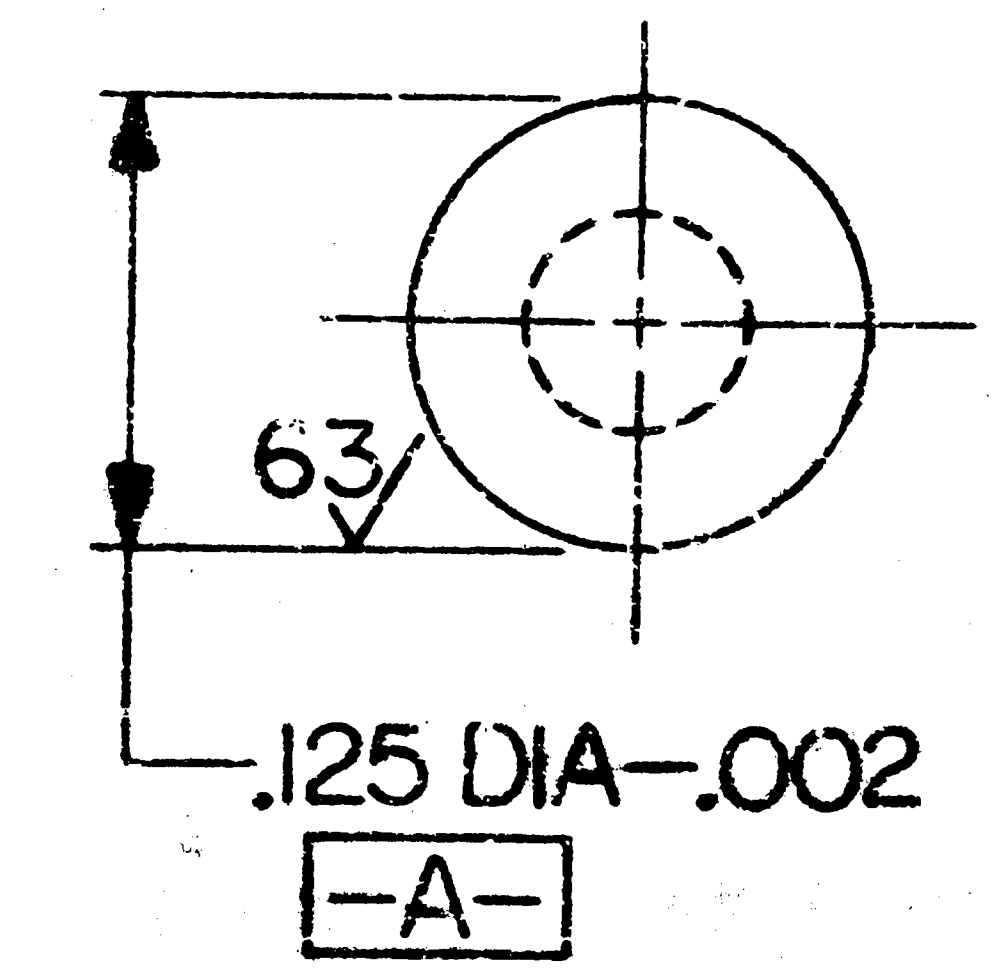
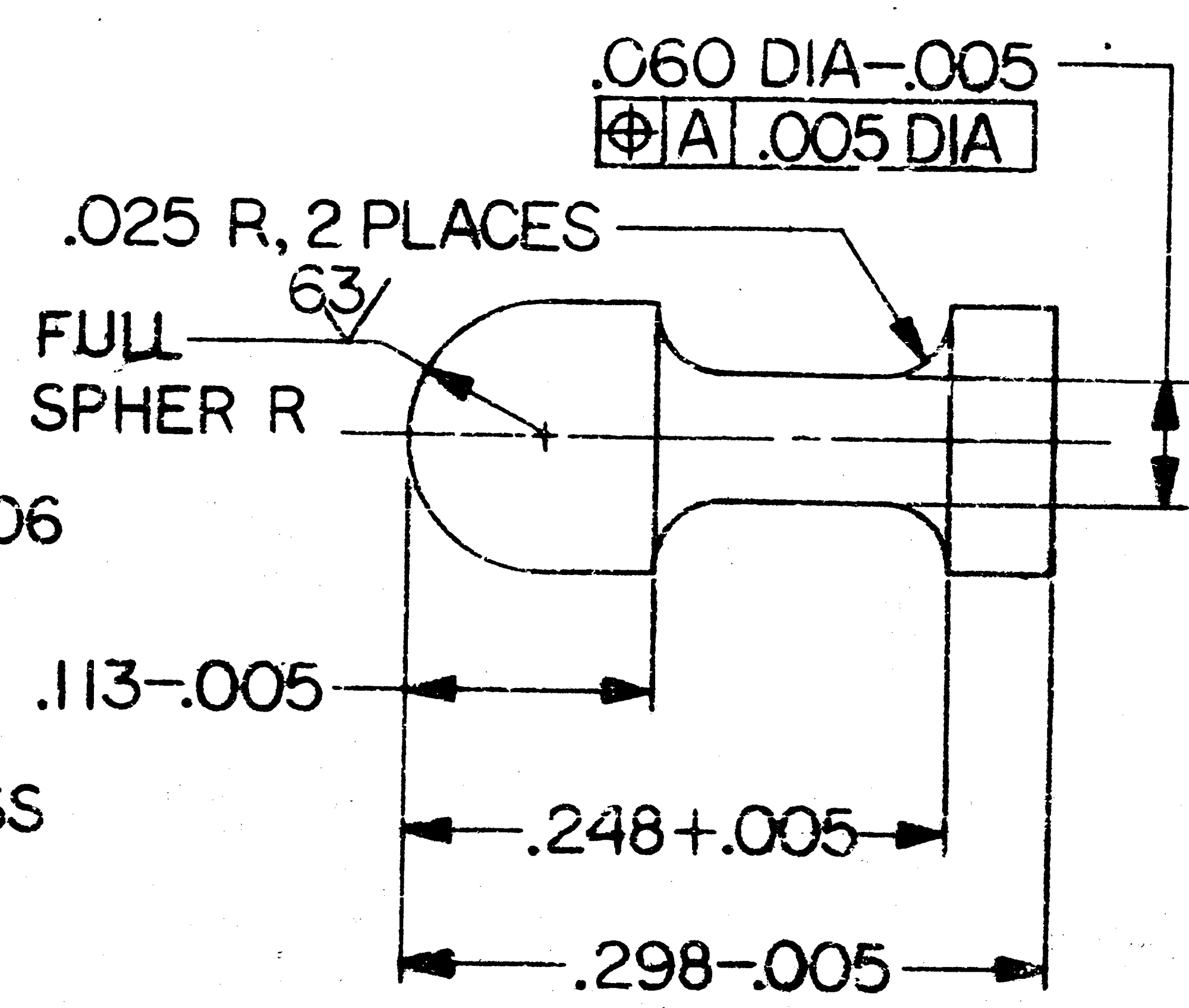
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REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	NOR W9S2003 80-02-13	80-05-16
		B	NOR W3S2023/ 83-06-06	83-09-14

NOTES:

1. FINISH $\sqrt{125}$ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 MAX.
3. CARBURIZE .003 TO .006 TOTAL CASE DEPTH.
4. HEAT TREATMENT: QUENCH AND TEMPER TO SURFACE HARDNESS 15 N 90 MIN.
5. FINISH 5.3.1.2 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT DESIGN ACTIVITY FSCM NO.19200

PART NO. 8448786

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.	
YS MIN		ANGLES ±		DATE	15 SEPT 72
YS MAX		3 PLACE DECIMALS ± .005		PREP	R. H. H. H.
EL 2		2 PLACE DECIMALS ±		CHK	R. H. H. H.
RA	D 8448525	M 231	STEEL CMPSN 1117	ENGR	R. H. H. H.
BH	D 8448525	M16/M16A1	SPEC ASTM A108	SUBMITTED	R. H. H. H.
PH	SEE NOTE 4	NEXT ASSY USED ON	FINAL PROTECTIVE FINISH	APPROVED	R. H. H. H.
		APPLICATION	SEE NOTE 5		

LATCH, COVER

SIZE CODE IDENT NO. DRAWING NO.
B 19204 8448786

8448786

5 4 3 2 1

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REVISIONS				
MF	ZONE	LTR	DESCRIPTION	DATE
		A	SEE ERR HQR 20778	6 OCT 72
		B	NOR W3S2009 80-02-13	80-05-16
		C	NORW2S2015 82 08 20	83 02 03
		D	NOR W2S0011 / 82-04-13 (ECP W3S3120 / 83-07-07)	83-11-04

SPRING, HELICAL, COMPRESSION

- NOTES:
- WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
 - PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITION CH900. HOLD AT 900°F ± 10°F FOR ONE HOUR. AIR COOL.
 - FINISH 5.4J OF MIL-STD-171.
 - MIL-W-13855 APPLIES.
 - BREAK SHARP EDGES .003 + .012.

WIRE DIAMETER _____ .0120 ± .0003
COIL DIAMETER (OD) _____ .120 ± .002
FREE LENGTH _____ .413 REF
TOTAL COILS _____ 8 REF
DIRECTION OF HELIX _____ OPTIONAL
LOAD AT COMPRESSED LENGTH OF .201 _____ .80 LB ± .08 LB
LOAD AT COMPRESSED LENGTH OF _____
SPRING RATE _____ 3.77 LB/IN REF
SOLID LENGTH _____ .0984 MAX
TYPE OF ENDS _____ CLOSED, GROUND
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

CURRENT FSCM NO.
PART NO. 8448787 19200

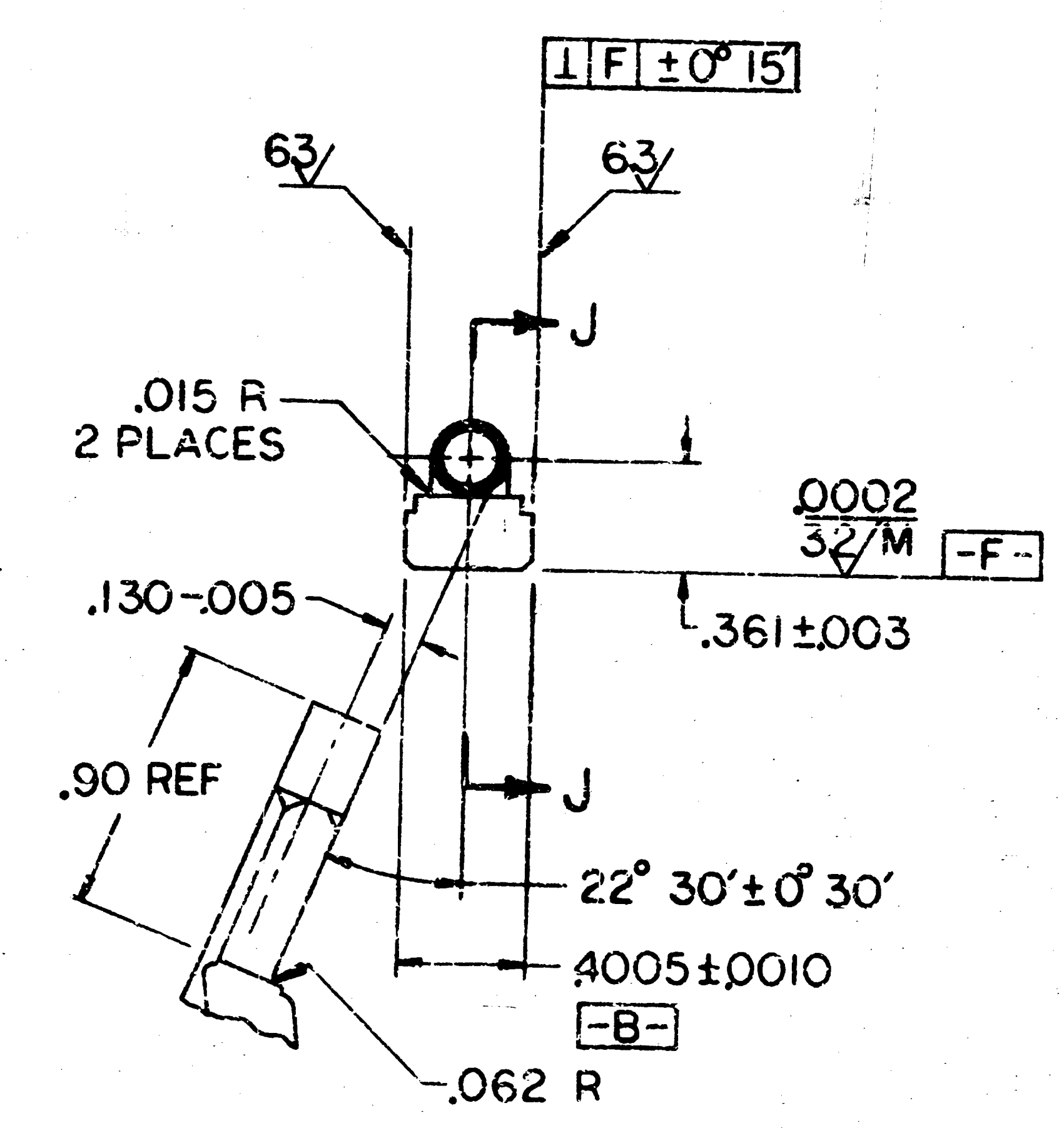
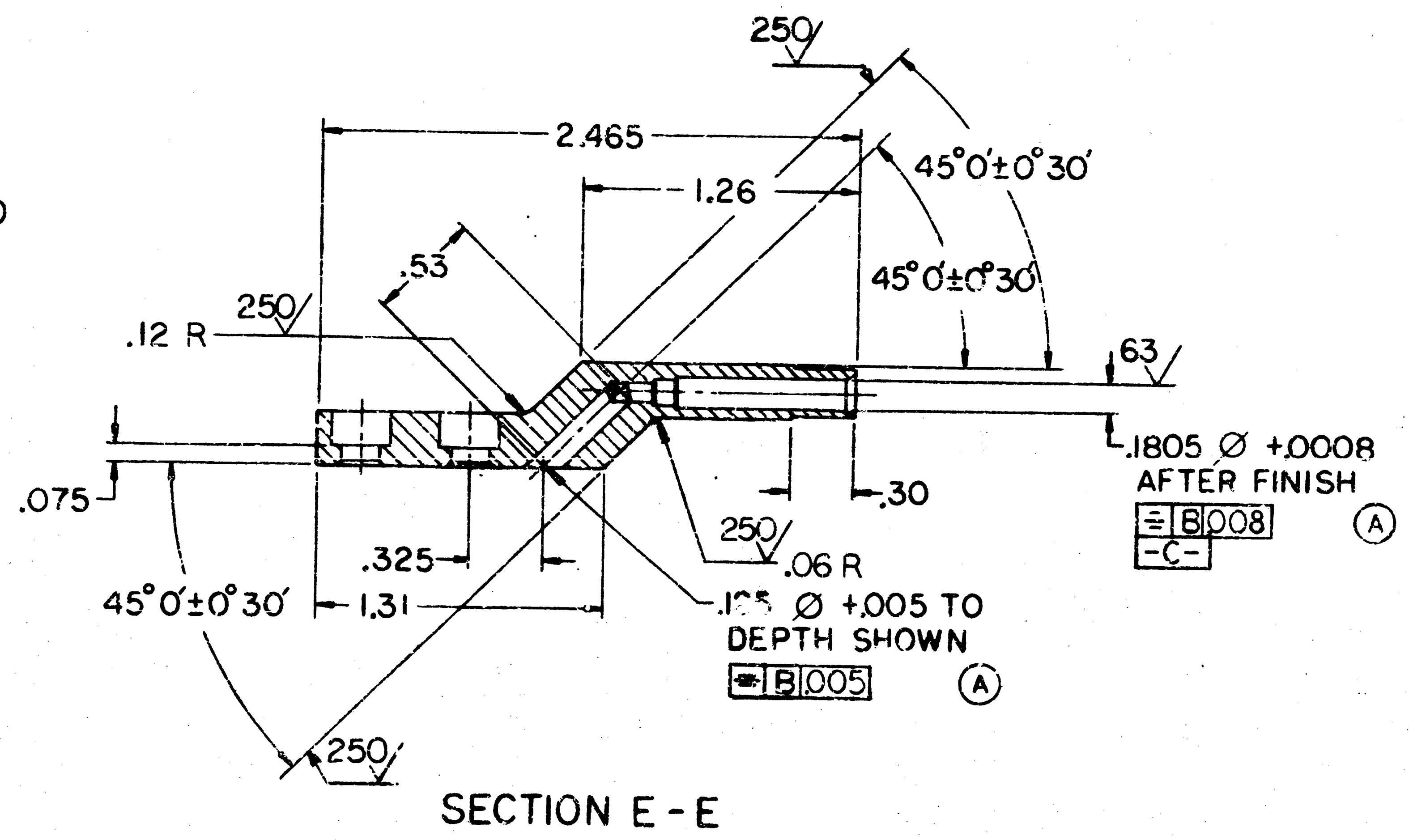
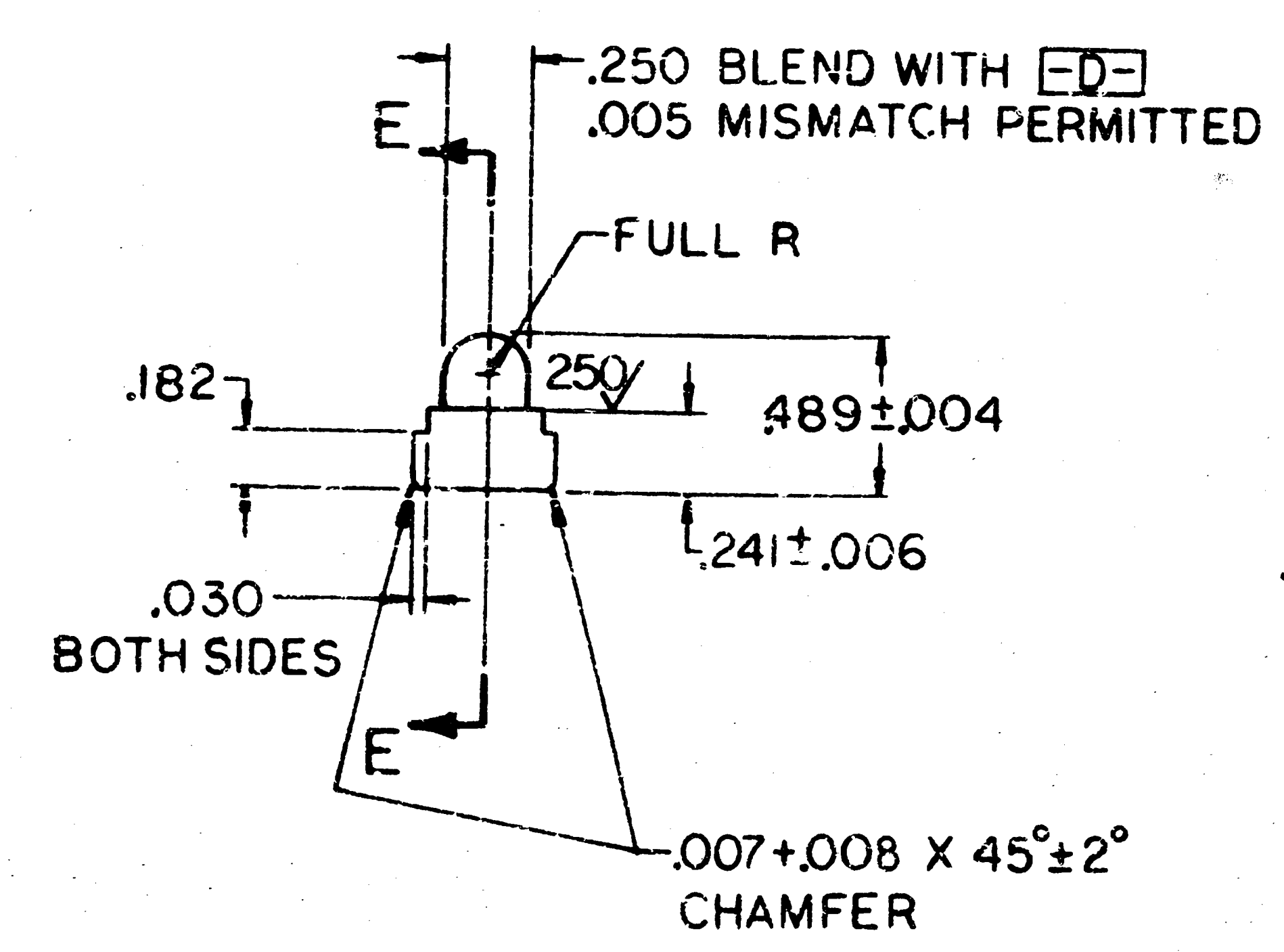
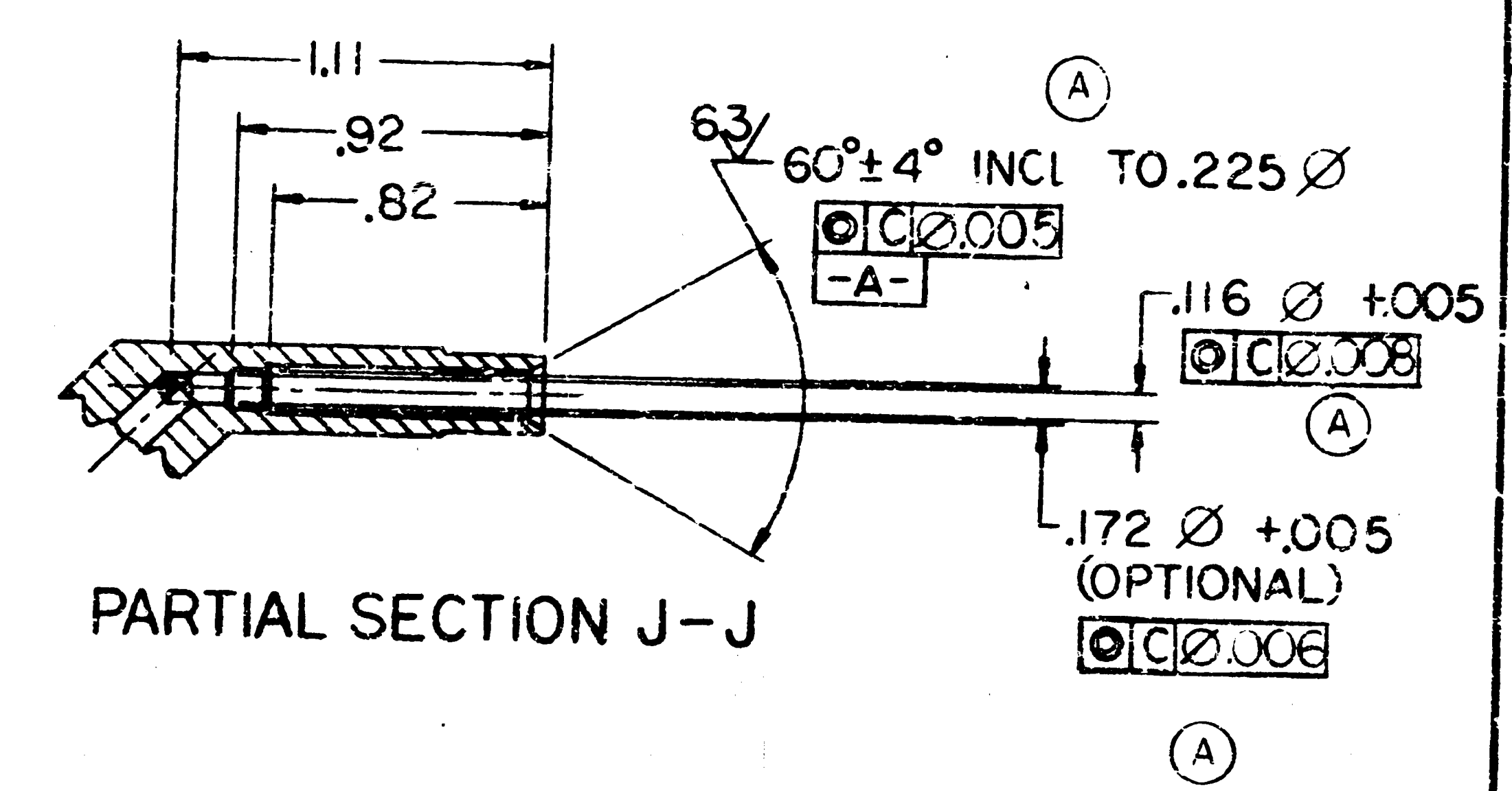
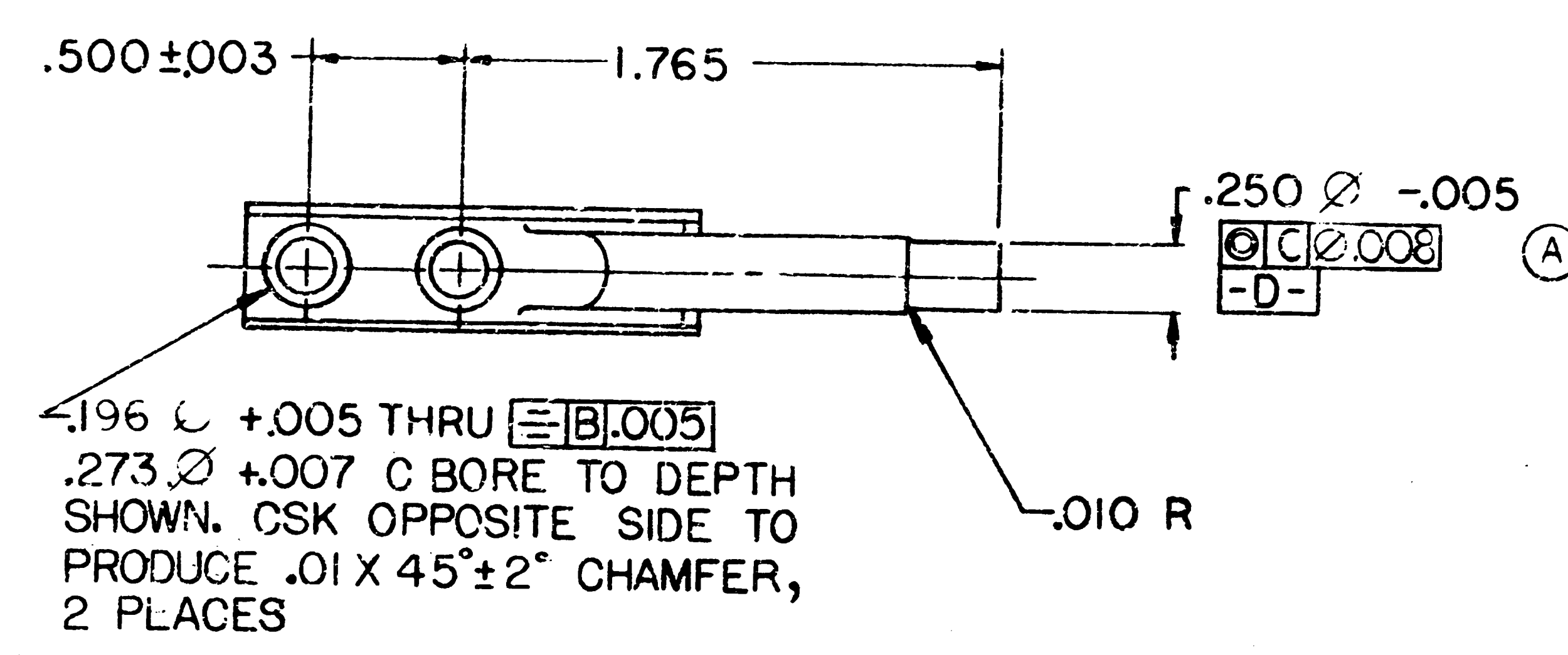
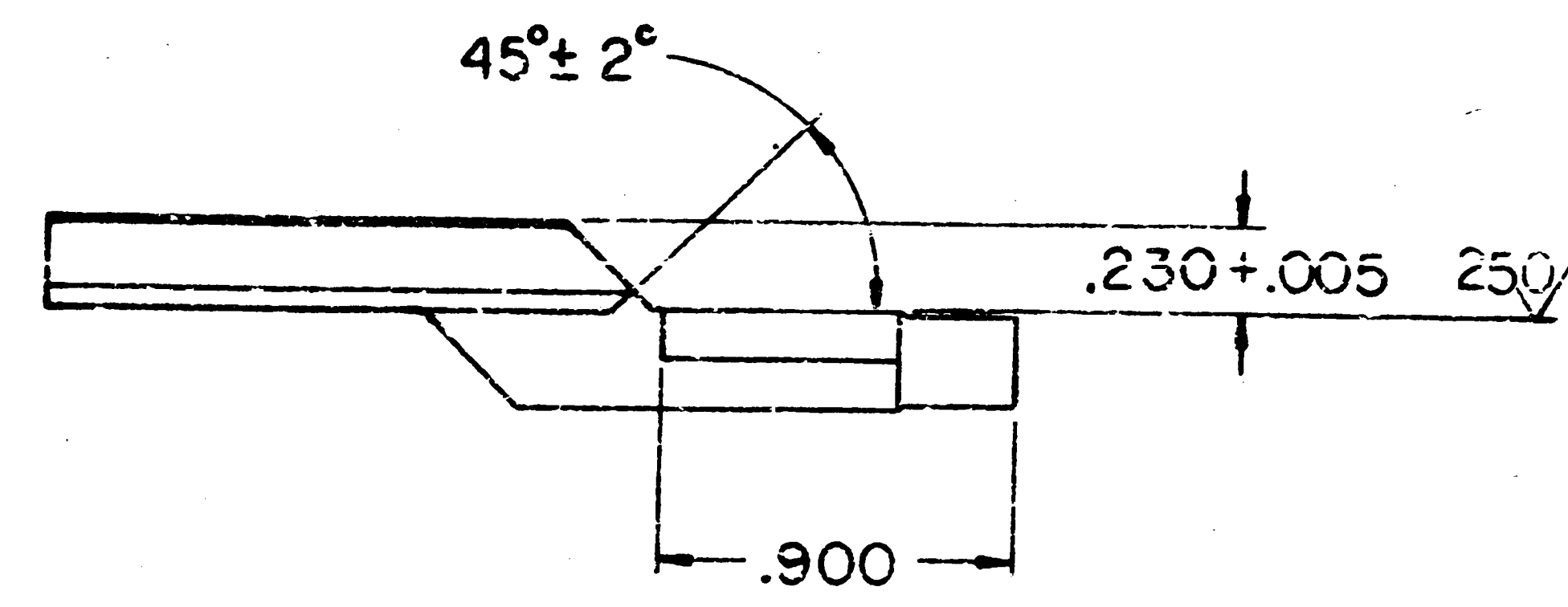
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MIN		TOLERANCES:		DATE 15 SEPT 72		SPRING, COVER LATCH	
YS MAX		ANGLES ±		PREP <i>R. Henry</i>			
EL 2		3 PLACE DECIMALS ±		CHK <i>J. Bunker</i>			
RA		2 PLACE DECIMALS ±		ENGR <i>R. Bunker</i>			
BH		D8448525	M 231	SUBMITTED <i>Loren Bunker</i>			
RH	15N 845 MIN	D8448525	M16/M16A1	APPROVED <i>R. S. Henry</i>			
		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH		SIZE CODE IDENT NO. DRAWING NO.	
		APPLICATION		SEE NOTE 1		B 19204 8448787	
				SEE NOTE 3		SCALE SHEET OF	

8 7 6 5 4 3 2 1

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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVED
A	REVISED DWG TO AGREE WITH LATEST ENGINEERING CHANGES.	73-04-14	24
B	ERR W952305	79-07-16	22

- NOTES:
- 1-SPEC MIL-W-13855 AND ANSI Y14.5 1973 APPLY. (A)
 - 2-FINISH 125/ EXCEPT AS NOTED.
 - 3-SUGGESTED HEAT TREAT PROCEDURE:
OIL QUENCH FROM 1575°F. TEMPER
AT 1100°F FOR 1 HOUR.
 - 4-FINISH 1.2.2.2 OF MIL-STD-171 ON DIA
[A-] AND [C-]. FILM THICKNESS
.0002/.0003.
 - 5-ALL OTHER SURFACES TO RECEIVE
FINISH 5.3.1.2 OF MIL-STD-171.



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		PART NO. 9327041	
YS		TOLERANCES:		DATE DEC 9, 1977		U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT COMMAND DOWRY, NEW JERSEY 07001	
MIN		ANGLES:		PREPARED (S) (S) (S)		KEY, BOLT CARRIER	
YS		3 PLACE DECIMALS ±.005		CHECKED (S) (S) (S)			
MAX		2 PLACE DECIMALS ±.01		ENGINEER (S) (S) (S)			
EL 2				SUBMITTED (S) (S) (S)			
RA		MATERIAL		APPROVED (S) (S) (S)		STEP CODE IDENT NO. DRAWING NO.	
SH		STEEL, AISI 4130				D 19200 9327041	
RH	C26-32	GUN QUALITY				SCALE 2/1	
		MAX BHN 229				SHEET	
		NEXT ASSY USED ON					
		APPLICATION					
		FINAL PROTECTIVE FINISH					
		SEE NOTES 3 & 4					

NOTES:-
 1- SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.
 (A) 2- MATERIAL: SCREW, CAP HEX SOCKET HEAD-B9349327 TO BE ALTERED AS INDICATED. (A)

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	REVISED DWG TO AGREE WITH LATEST ENG'RING CHANGES	79-04-10	<i>[Signature]</i>
B	ERR W9S 2505	79-07-16	<i>[Signature]</i>
C	NOR WIS5002	81-12-02	81-12-16 <i>[Signature]</i>

ALTERED ITEM DRAWING
PART NO. 9327042

MECHANICAL PROPERTIES YP TS EL2 RA BH RH		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ± FRACTIONS ± ANGLES ±		ORIGINAL DATE OF DRAWING OCT 24, 1977		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND DOVER, NEW JERSEY 07801	
				DRAFTSMAN <i>R.K.</i>	CHECKER	SCREW, BOLT CARRIER KEY	
APPLICATION 9327071 M231, PORT FIRING, 5.56MM, SMG NEXT ASSY USED ON		ENGR <i>[Signature]</i>	ENGR	SIZE B	CODE IDENT NO. 19200		
		ENGR <i>[Signature]</i>	ENGR <i>[Signature]</i>	SCALE 4/1	UNIT WT.	SHEET	

BARPA FORM 1039 OCT 75 EDITION OF OCT 70. MAY BE USED

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1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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AS SHOWN



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U S ARMY COMBATANT RESEARCH AND DE

SCALE 271

Page 2

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NOTICE: RESTRICTIONS AS TO USE AND DISCLOSURE

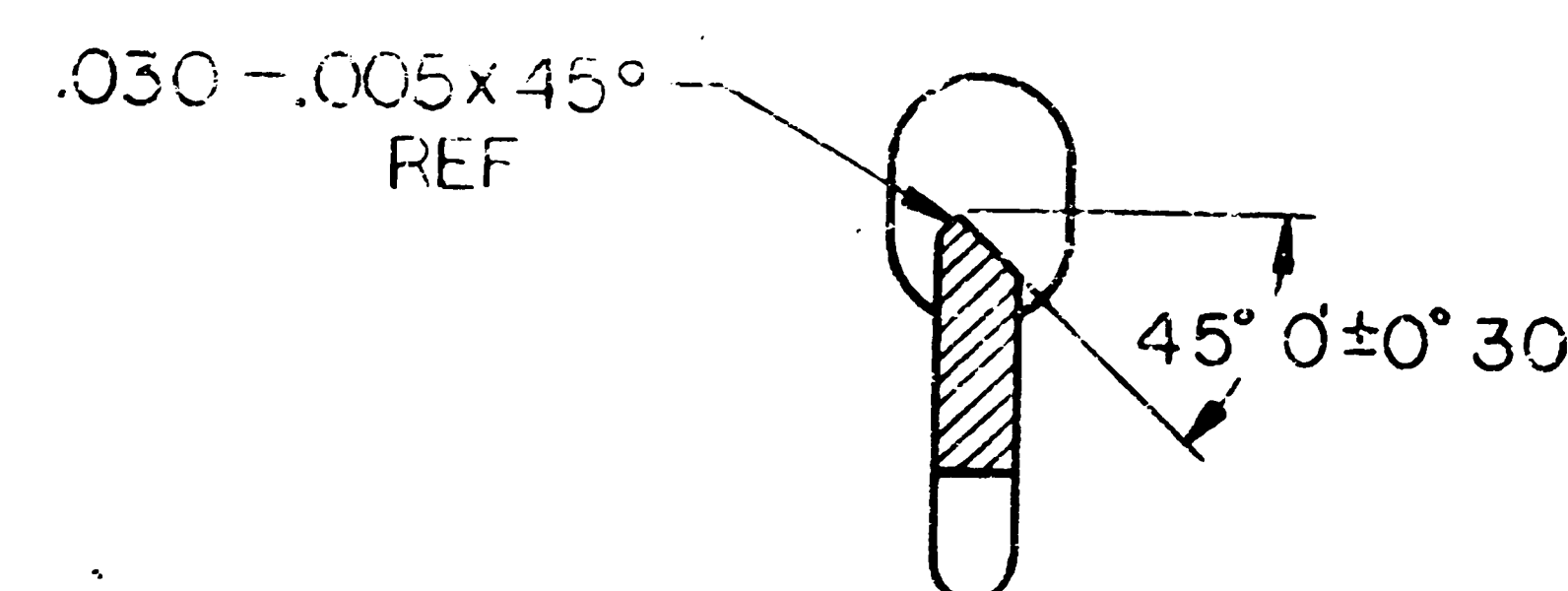
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NOTES:

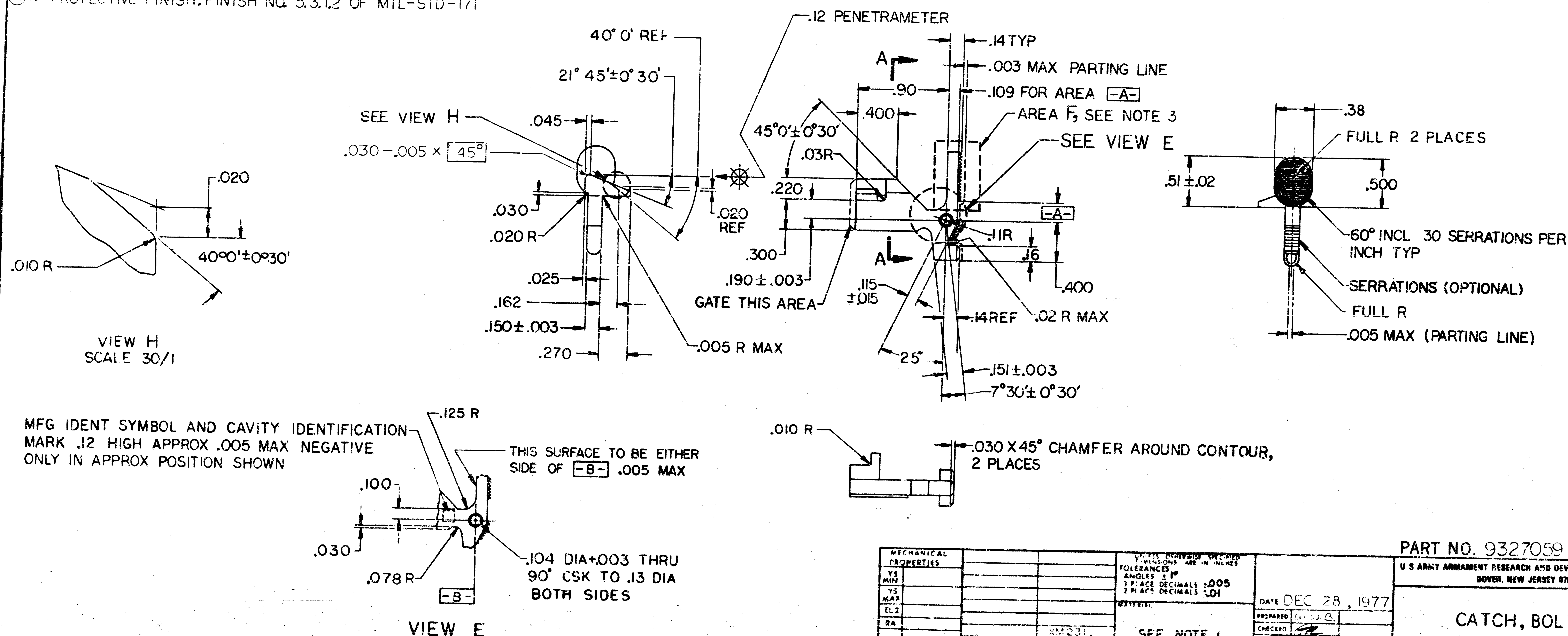
1. SPEC MIL-W-13855 & ANSI-Y14.5-1973 APPLY.
2. STEEL, INVESTMENT CASTING, CMPSN IC8620, SPEC MIL-S-22141, EXCEPT THAT MANGANESE CONTENT SHALL BE .70 TO 1.20 %.
3. CLASSIFICATION AND INSPECTION OF CASTINGS SHALL BE IN ACCORDANCE WITH CLASS 2A, GRADE A, SPEC MIL-C-6021, EXCEPT CLASS 1B, GRADE C IS PERMISSIBLE IN AREA F.
4. FINISH $\frac{1}{25}$ EXCEPT AS NOTED.
5. EJECTOR PIN MARKS .010 NEGATIVE MAX.
6. CARBURIZE TO PRODUCE A TOTAL CASE DEPTH OF .014 TO .018.
7. PROTECTIVE FINISH: FINISH NO. 5.3.1.2 OF MIL-STD-171

SYM	REVISIONS	DATE	APPROVED
A	REVISED DWG TO AGREE WITH LATEST ENG'RING CHANGES.	790419	
B	FRM WAS 2505	790716	

.220 GRIND GATE TO THIS DIMENSION



SECTION A-A



MFG IDENT SYMBOL AND CAVITY IDENTIFICATION MARK .12 HIGH APPROX .005 MAX NEGATIVE ONLY IN APPROX POSITION SHOWN

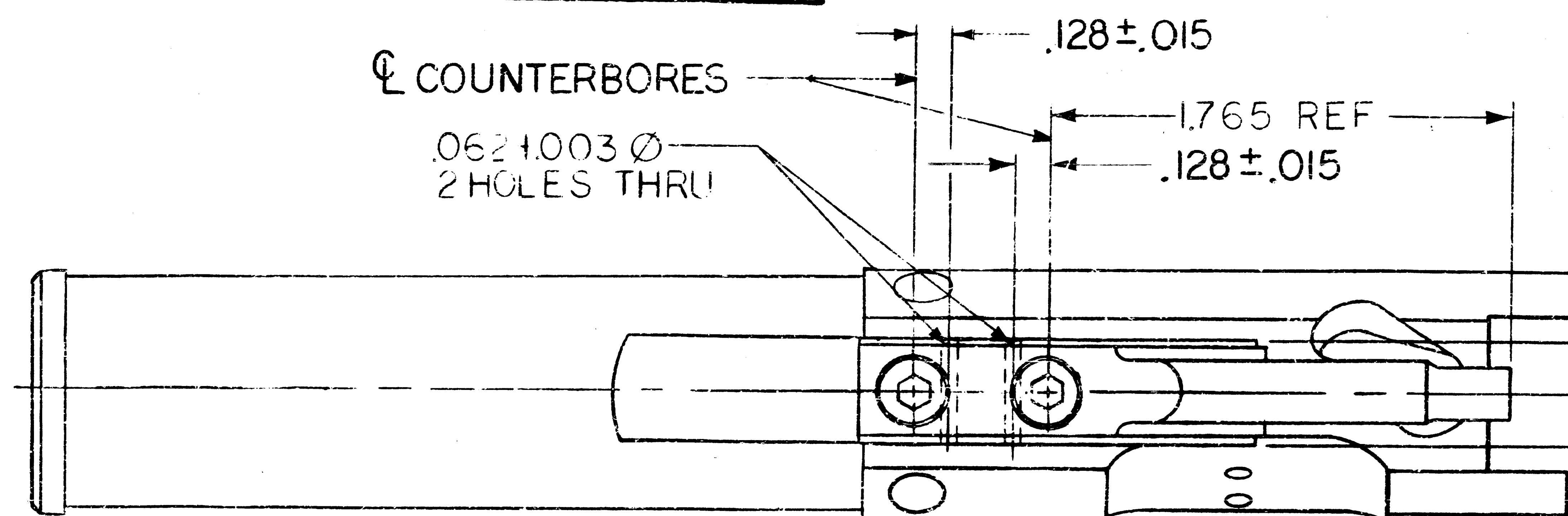
VIEW E

MECHANICAL PROPERTIES		TOLERANCES UNLESS OTHERWISE SPECIFIED		PART NO. 9327059	
YS		DIMENSIONS ARE IN INCHES		U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND	
MIN		TOLERANCES		DOVER, NEW JERSEY 07801	
MAX		ANGLES		CATCH, BOLT	
EL2		3 PLACE DECIMALS .005		DATE DEC 28, 1977	
RA		2 PLACE DECIMALS .01		PREPARED BY 10000	
BM		EXTERNAL		CHECKED BY 10000	
RM	15N 89.5	9327230		ENGINEER	
	-91.0	NEXT ASSY USED ON		SUBMITTED	
APPLICATION		SEE NOTE 7		APPROVED	

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F NORW252504 / 82-09-15				REVISIONS		
SYM	DESCRIPTION	DATE	APPROVED			
A	2 SPRING PINS ADDED WITH DIM AND CALLOUTS	9-20-78	<i>[Signature]</i>			
B	REVISED DWG TO AGREE WITH LATEST ENGRING CHANGES	79-04-18	<i>[Signature]</i>			
C	ERR W9S 2505	79-07-16	<i>[Signature]</i>			
D	NOR WIS5000 81-05-11	81-05-29	<i>[Signature]</i>			
E	NOR WIS5002 81-12-02	81-12-16	<i>[Signature]</i>			

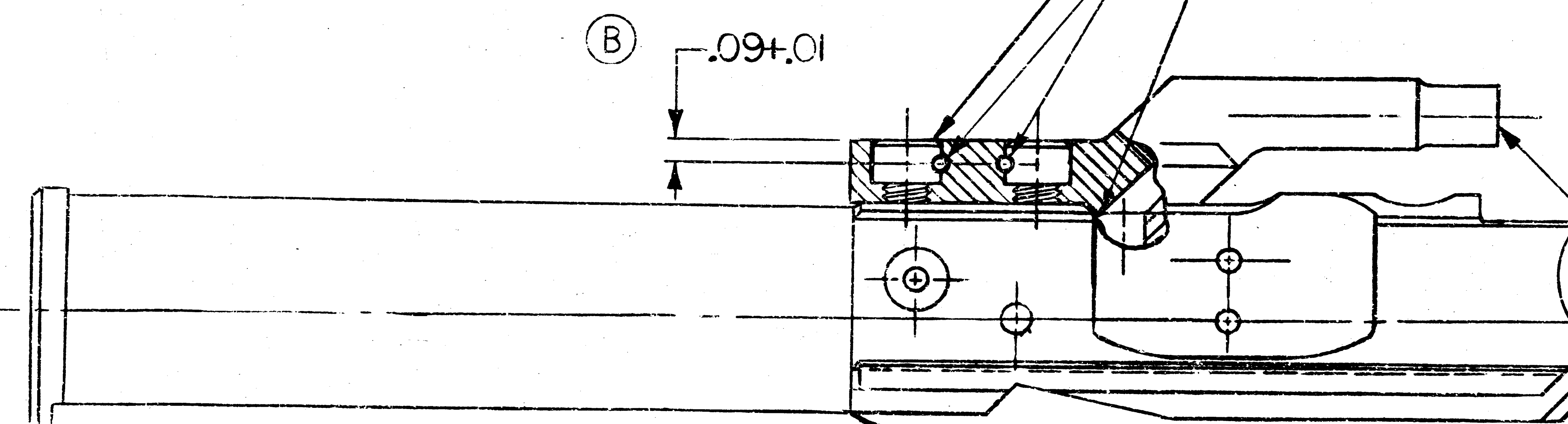


NO DISTORTION PERMISSIBLE ON THESE SURFACES.

2-SCREW, BOLT CARRIER KEY — 9327042
TIGHTENING TORQUE 60 LB IN. ± 5 LB IN.

APPLY PERMATEX NO.3D AVIATION FORM-A-GASKET (LIQUID) AROUND GAS HOLE ONLY ON BOLT CARRIER PRIOR TO ASSEMBLY.

2-MS16562-98 SPRING PIN



FOR U.S. GOVERNMENT
USE ONLY

KEY, BOLT CARRIER — 9327041

CARRIER, BOLT — 9327047
SEE SEPARATE PARTS LIST 9327071

PART NO. 9327071

NOTE:

- SPEC MIL-W-13855 AND Y14.5-1973 APPLY.
- APPLY FINISH NO.30.7, MIL-STD-171 TO ALL EXTERNAL RUBBING SURFACES OF THE BOLT CARRIER AND THE BOLT CARRIER KEY IN THEIR ASSEMBLED CONFIGURATION

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES:		DATE DEC 9, 1977		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND DOVER, NEW JERSEY 07801	
YS				ANGLES	±			KEY AND BOLT CARRIER ASSEMBLY	
MIN				3 PLACE DECIMALS	±.005				
YR				2 PLACE DECIMALS	±.01			C 19200 9327071	
MAX				MATERIAL					
EL 2				M231				SCALE 2/1	
RA				PORT FIRING, 5.56MM, SMG					
3H				9327072				SHEET 1 OF 1	
RH				NEXT ASSY USED ON					
APPLICATION				FINAL PROTECTIVE FINISH					

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1- SPEC MIL-W-13855 AND ANSI Y14.5-73
APPLY.

2- MATERIAL:-STEEL, COLD DRAWN BAR
CMPSN 1117 THRU 1144, SPEC ASTM-A108.
ALTERNATE MATERIAL:- STEEL AISI 1042

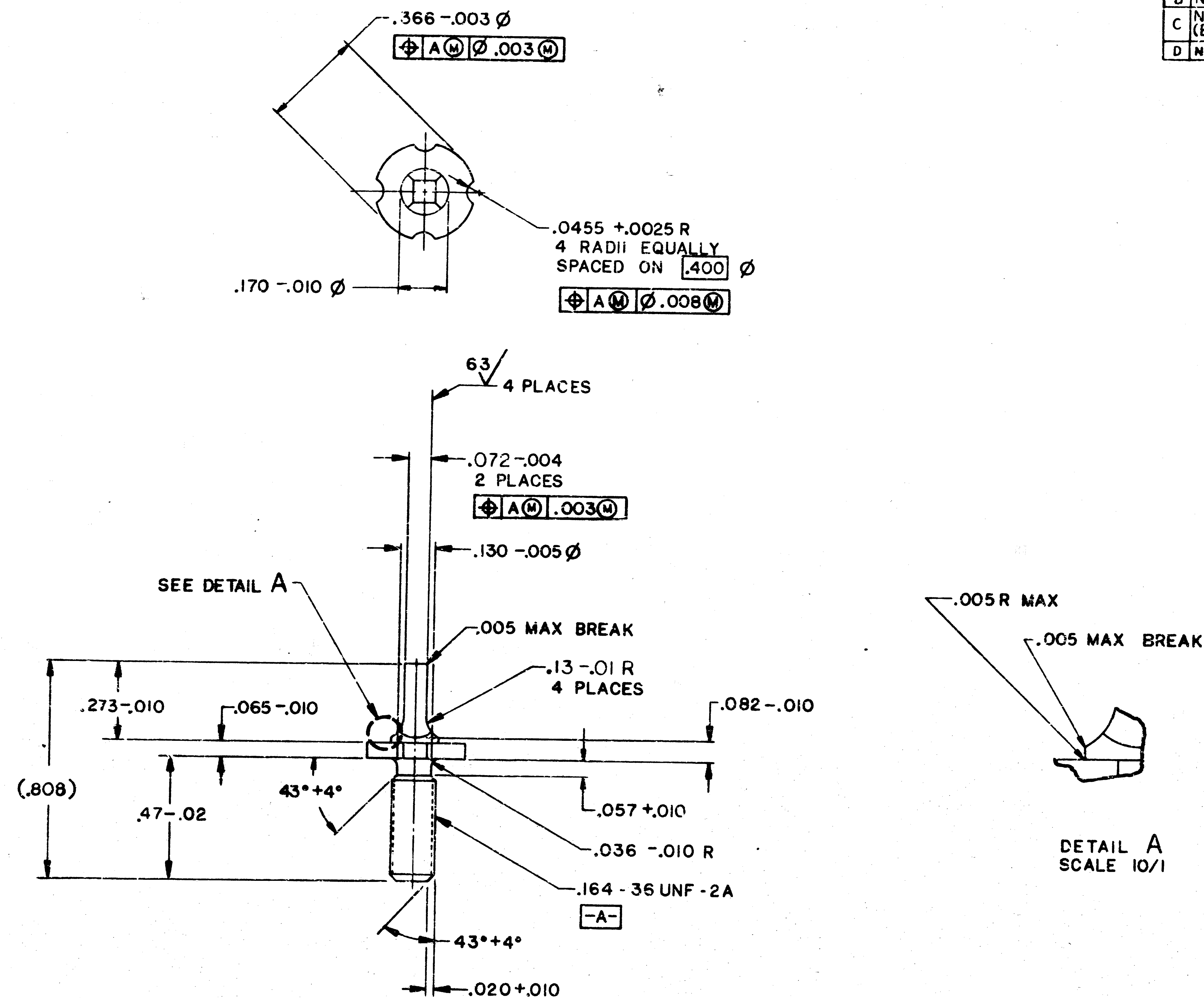
3- ALL DIMENSIONS ARE BEFORE PROTECTIVE
FINISH.

4- BREAK SHARP EDGES .005+0.010 EXCEPT AS
NOTED.

5- FILLET RADII .015-.012

6- FINISH $\sqrt{125}$ ALL OVER

7- PROTECTIVE FINISH:- 5.3.1.2 OF MIL-STD-171.



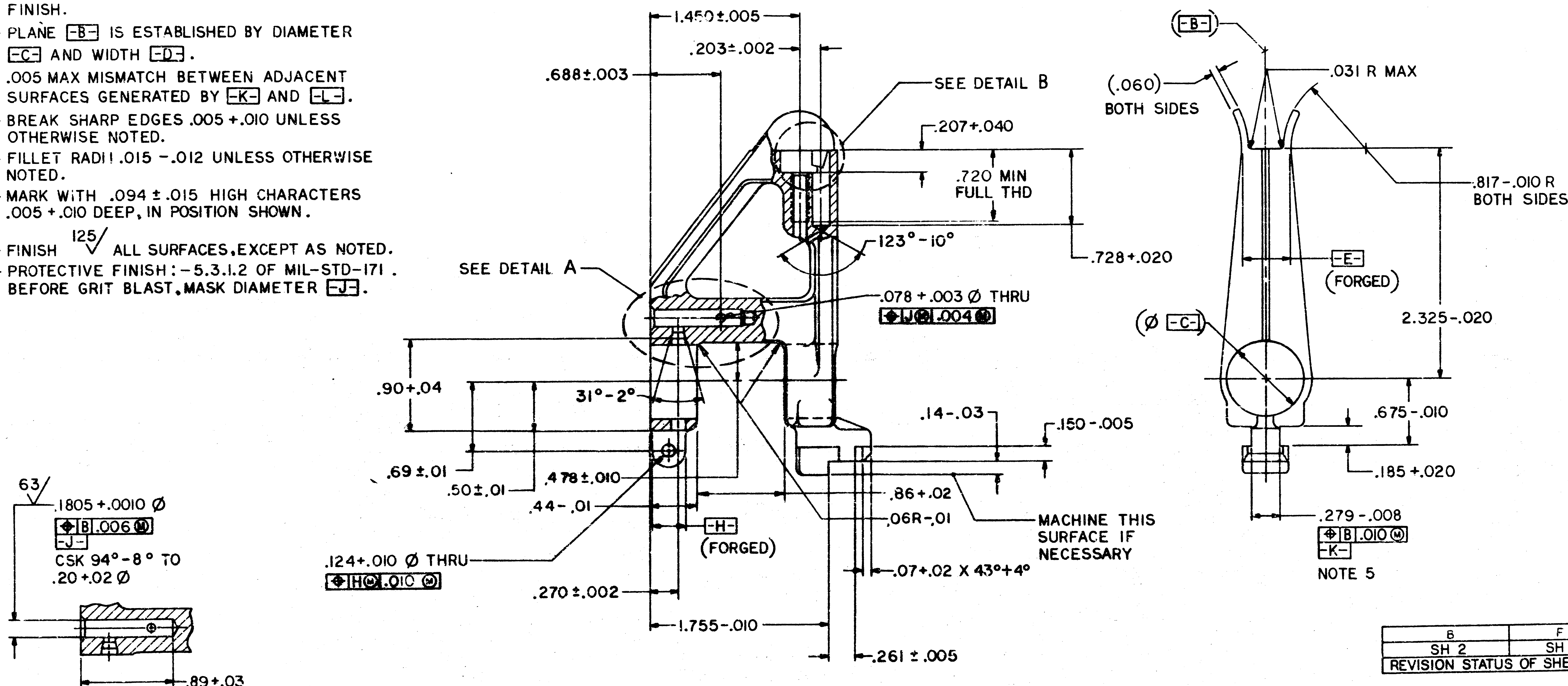
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW52013	820614	<i>[Signature]</i>
A	NOR W452016 / 84-05-13	84-06-07	<i>[Signature]</i>
B	NOR W452018 / 82-12-30	84-09-04	<i>[Signature]</i>
C	NOR W453014 / 84-06-01 (ECPW453024 / 84-07-24)	841005	<i>[Signature]</i>
D	NOR W450030 / 84-11-15	850402	<i>[Signature]</i>

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 82-06-09		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801		
		VP		TOLERANCES ON DECIMALS = FRACTIONS = ANGLES =		DRAFTSMAN M M	CHECKER JWH	POST, FRONT SIGHT		
		TS				ENGR <i>John A. Segan</i>	ENGR			
		ELC				ENGR	ENGR			
		RA				ENGR	ENGR			
9349050	M16A2	BR				<i>John Segan</i> <i>J. A. Segan</i>		SIZE D	FSCM NO. 19200	9349056
NEXT ASSY	USED ON	RM						SCALE 4:1	UNIT WT.	SHEET 1 OF 2
APPLICATION										

1 - SPEC. MIL-W-13855 AND ANSI Y14.5-73
APPLY.


- 2 -- MAKE FROM FRONT SIGHT FORGING-8448643.
- 3 -- ALL DIMENSIONS APPLY BEFORE PROTECTIVE FINISH.
- 4 -- PLANE B IS ESTABLISHED BY DIAMETER C AND WIDTH D.
- 5 -- .005 MAX MISMATCH BETWEEN ADJACENT SURFACES GENERATED BY K AND L.
- 6 -- BREAK SHARP EDGES .005 +.010 UNLESS OTHERWISE NOTED.
- 7 -- FILLET RADI .015 -.012 UNLESS OTHERWISE NOTED.
- 8 -- MARK WITH .094 ± .015 HIGH CHARACTERS .005 +.010 DEEP, IN POSITION SHOWN.
- 9 -- FINISH ^{125/} ✓ ALL SURFACES, EXCEPT AS NOTED
- 10 -- PROTECTIVE FINISH: -5.3.1.2 OF MIL-STD-171 BEFORE GRIT BLAST, MASK DIAMETER J.

REVISONS			
S/N	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERW252013	820614	<i>W. H. B. B. B.</i>
A	NORW45 3021/84-07-24	841030	<i>W. H. B. B. B.</i>
B	NORW45 0030 / 84-11-15	850402	<i>W. H. B. B. B.</i>
C	NORW45 3071 / 85-02-08	850621	<i>W. H. B. B. B.</i>
D	NORW45 3050 / 85-12-11	870218	<i>W. H. B. B. B.</i>
E	NORGIS2018 / 91-07-08	91-10-11	<i>RE. L.</i>
F	NOR G353110 93-11-30	940323	<i>W. H. B. B. B.</i>



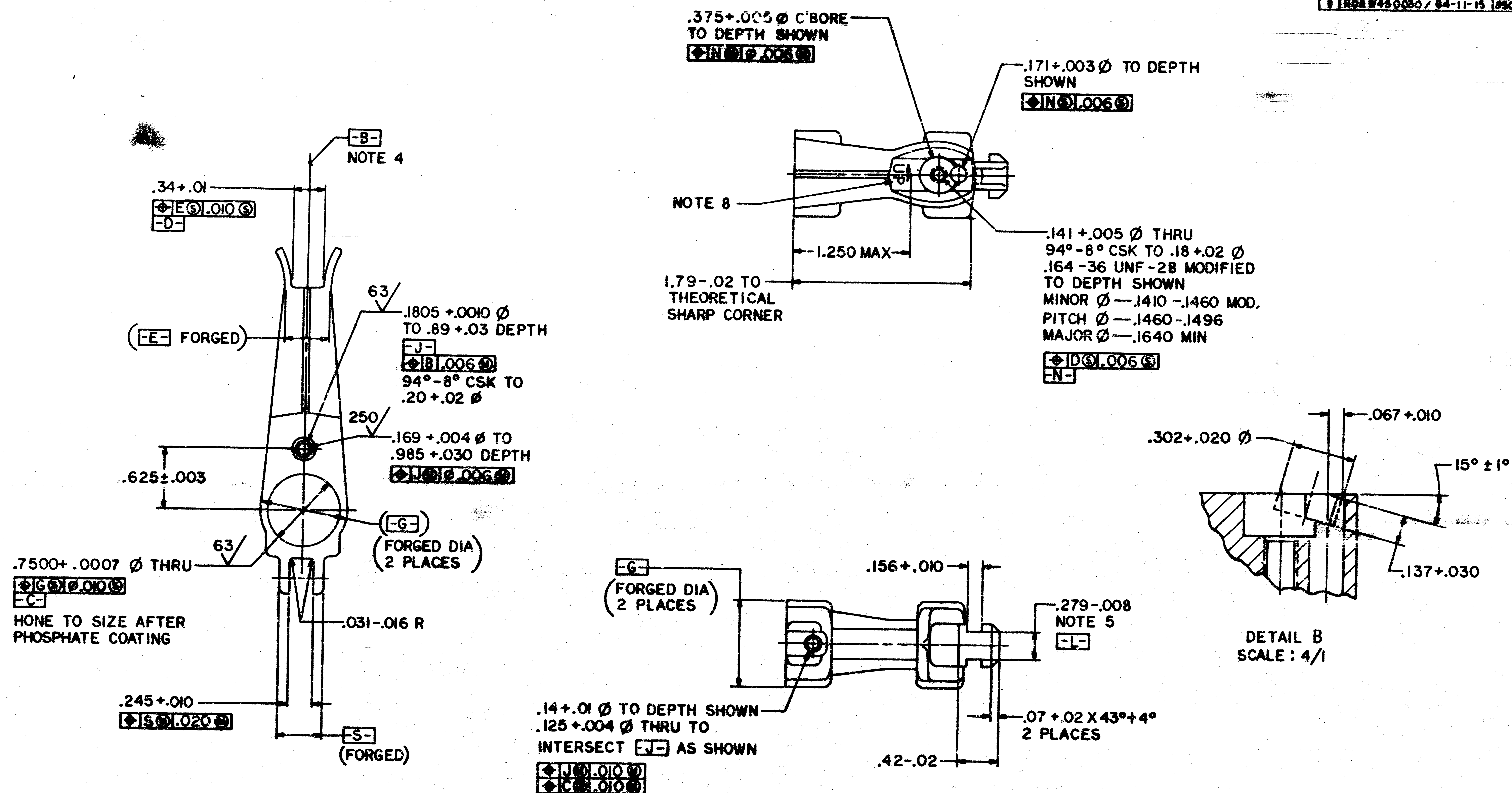
DETAIL A
ALTERNATIVE METHOD

DISTRIBUTION STATEMENT F
FURTHER DISSEMINATION ONLY AS DIRECTED
BY SMCRI-IMO-DR; 93-09-14 OR HIGHER
DoD AUTHORITY.

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 82-06-09		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801		
		YP		TOLERANCES ON DECIMALS * FRACTIONS * ANGLES *		DRAFTSMAN SMI		CHECKER JWH		
		TS				ENGR		ENGR		
		SLP				ENGR		ENGR		
		SA				ENGR		ENGR		
9390008		M4				 Robert J. McDaniel		SIZE	FSCM NO.	9349058
9349057		M16A1		D	19200					
NEXT ARMY		USED ON								
APPLICATION										
						SCALE 2 / 1		UNIT WT.	SHEET 1 OF 2	

NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

DATE	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW252013	820614	<i>[Signature]</i>
A	ERR W45302 / 84-07-24	841030	<i>[Signature]</i>
1	ERR W453080 / 84-11-15	850602	<i>[Signature]</i>

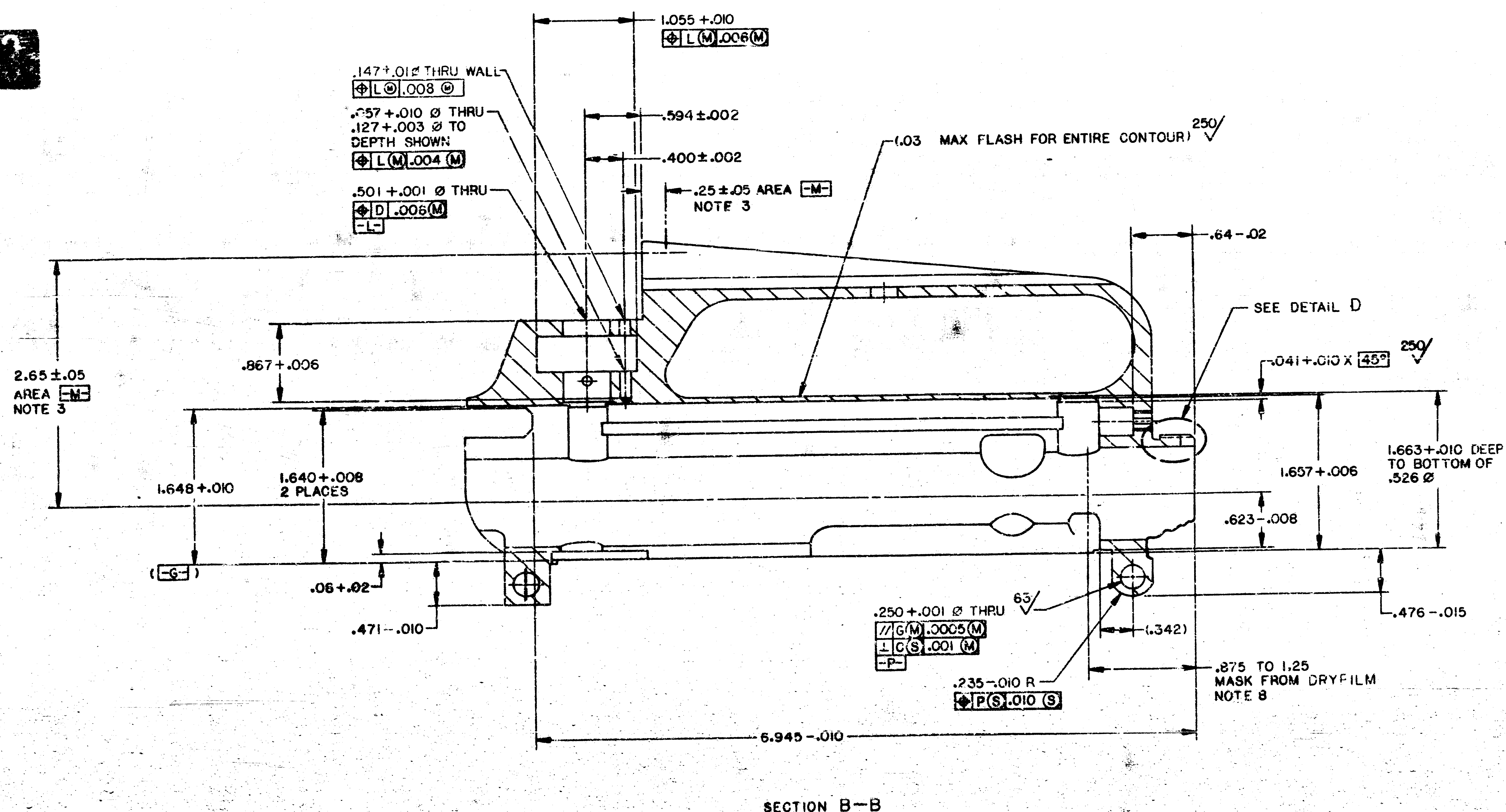
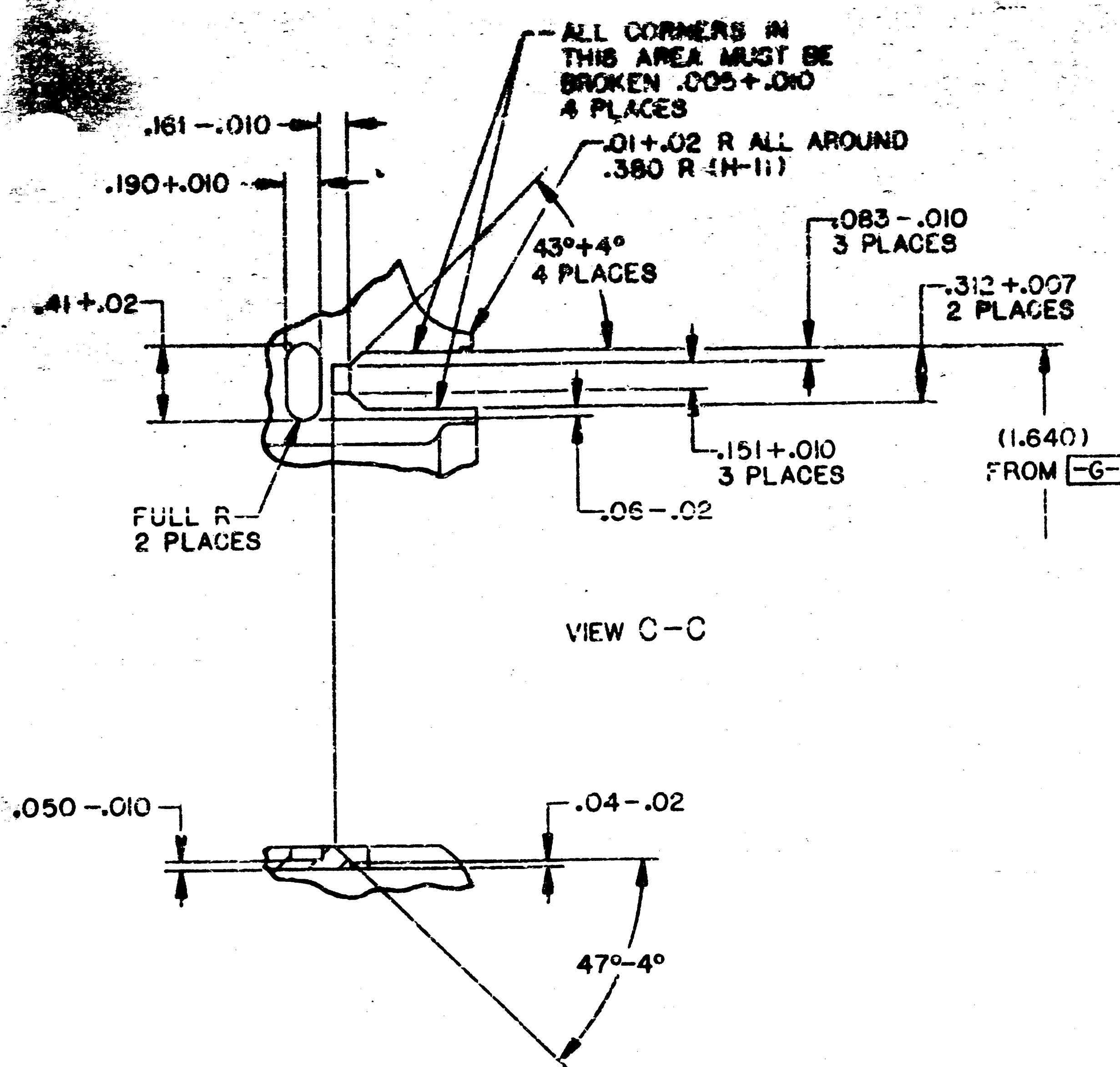


U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DURHAM, NEW JERSEY 07801

ONE D	FSCM NO. 19200	9349058
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11200	
1000 2 / 1	UNIT WT
	SECRET 2

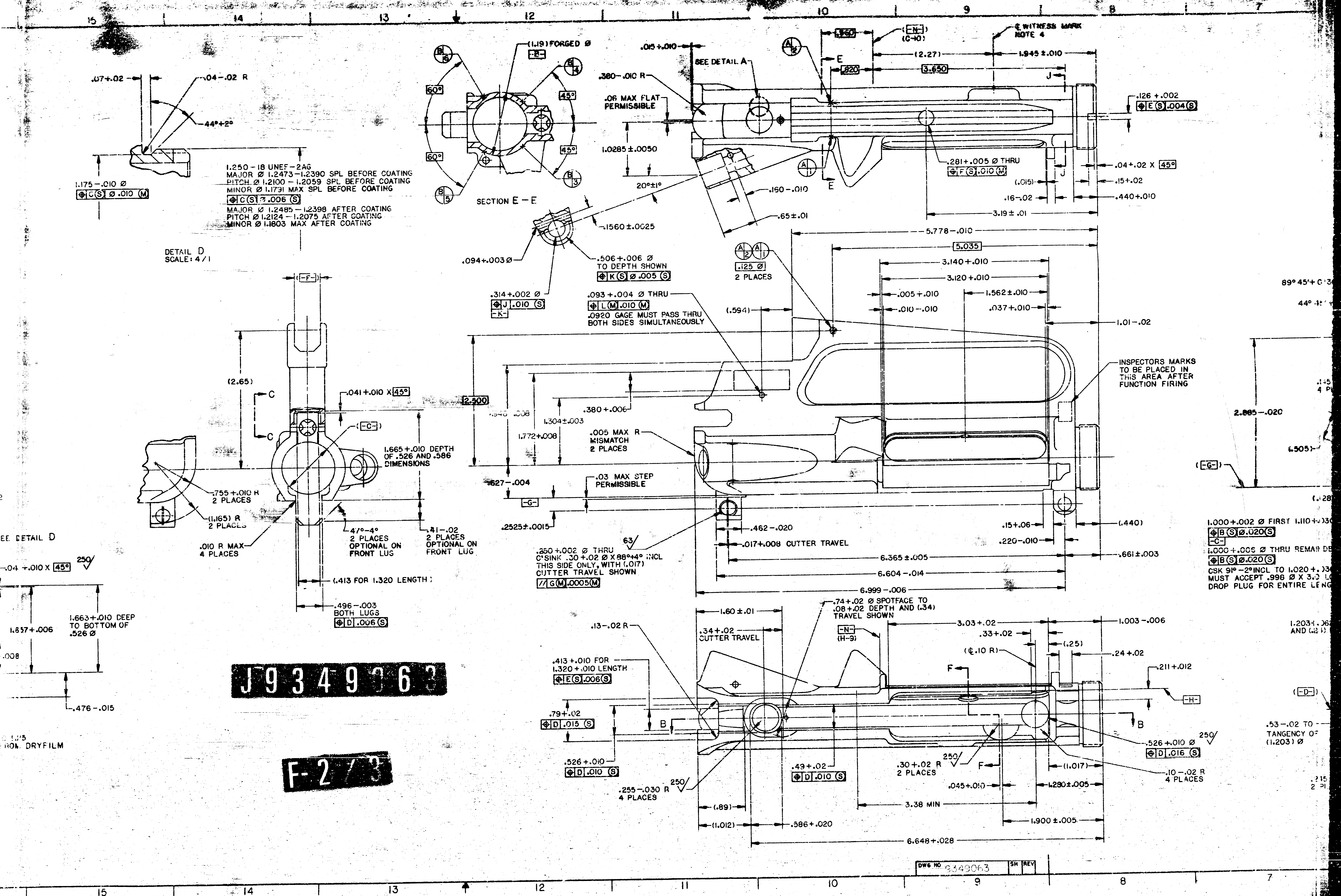
- 1 - SPEC MIL-W-13055 AND ANSI Y14.5 - 73 APPLY.
- 2 - MATERIAL:- MAKE FROM FORGING, UPPER RECEIVER -9349064.
- 3 - CENTER LINE D (G-6) AND J (D-5) ARE ESTABLISHED WHEN LOCATING ON Ø C, AND SLOT F AT AREA M (D-18).
- 4 - WITNESS MARK (H-9) TO DETERMINE STARTING POINT FOR MACHINING.
- 5 - ALL DIMENSIONS APPLY BEFORE PROTECTIVE FINISH UNLESS OTHERWISE NOTED.
- 6 - BREAK SHARP EDGES .005±.010 UNLESS OTHERWISE NOTED.
- 7 - FILLET RADII .015±.012 UNLESS OTHERWISE NOTED.
- 8 - EVERLUBE 626 OR 626S CURED AT 275°F ± 25°F FOR 1 HOUR OR MIL-L-46010 CURED 300°F TO 325°F FOR 2 HOURS, TO BE APPLIED AFTER PROTECTIVE FINISH TO INTERIOR EXCEPT FOR .375 TO 1.25 LENGTH (B-16). FILM THICKNESS .0002±.0001.
- 9 - FINISH ^{125/}✓ ALL MACHINED SURFACES, EXCEPT AS NOTED.
- 10 - PROTECTIVE FINISH:- MIL-A-8625, TYPE III CLASS 2, FILM THICKNESS .0010 ± .0002, FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NC.37033, TABLE IX BUT NOT LIGHTER THAN GRAY. 36076, TABLE VIII OF FED-STD-595 AND SEAL. GRIT BLAST PRIOR TO FINISH TO PROVIDE NON REFLECTIVE MATTE SURFACE AFTER FINISH.



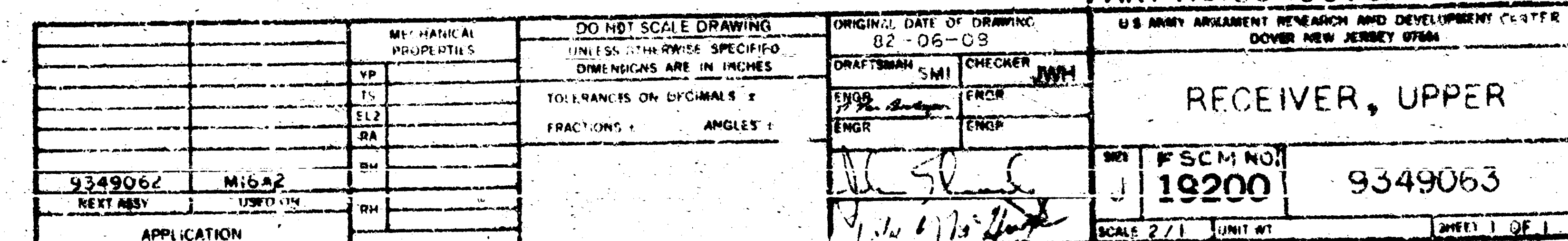
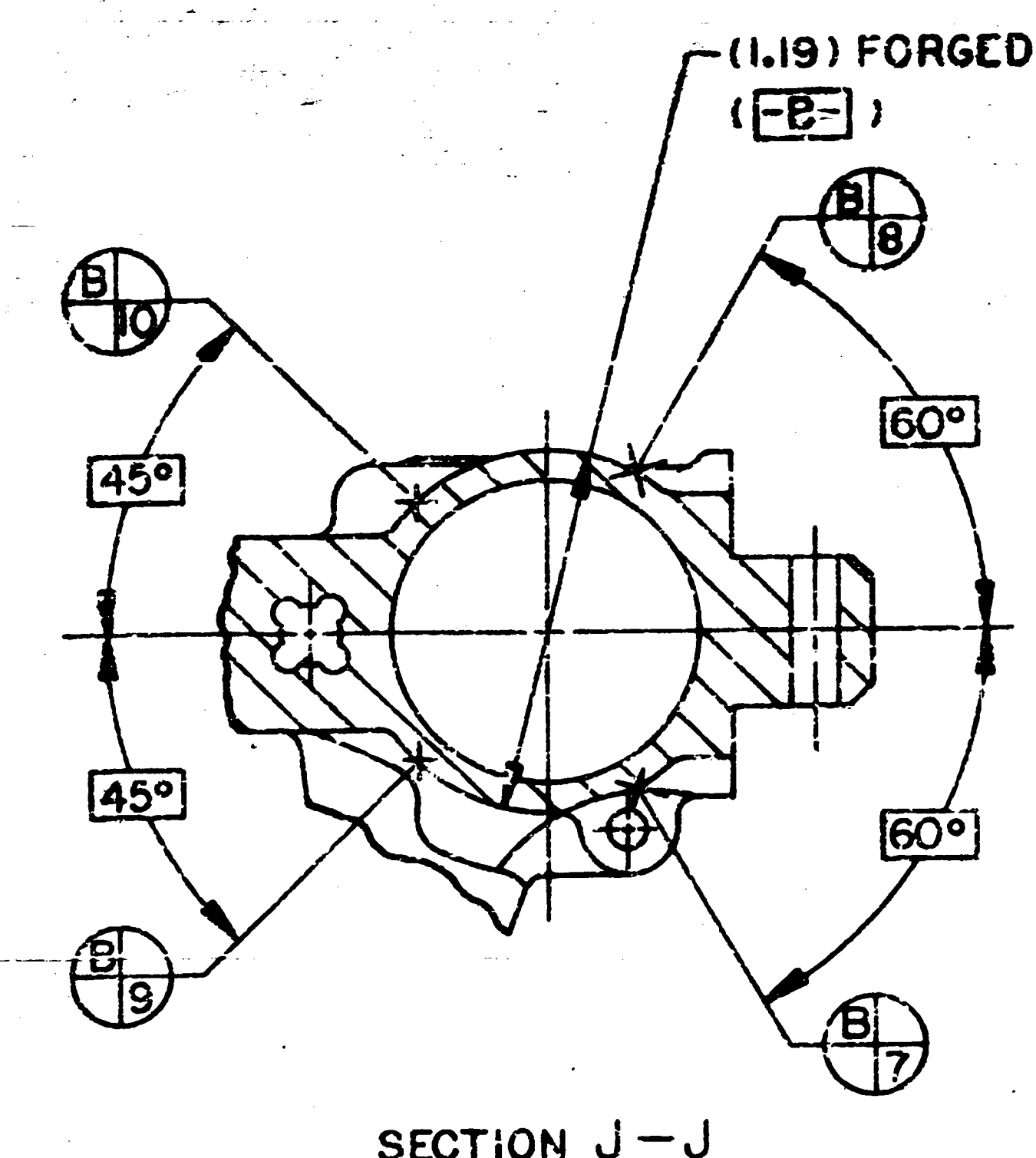
SECTION B-B

DWS NO. 9349063

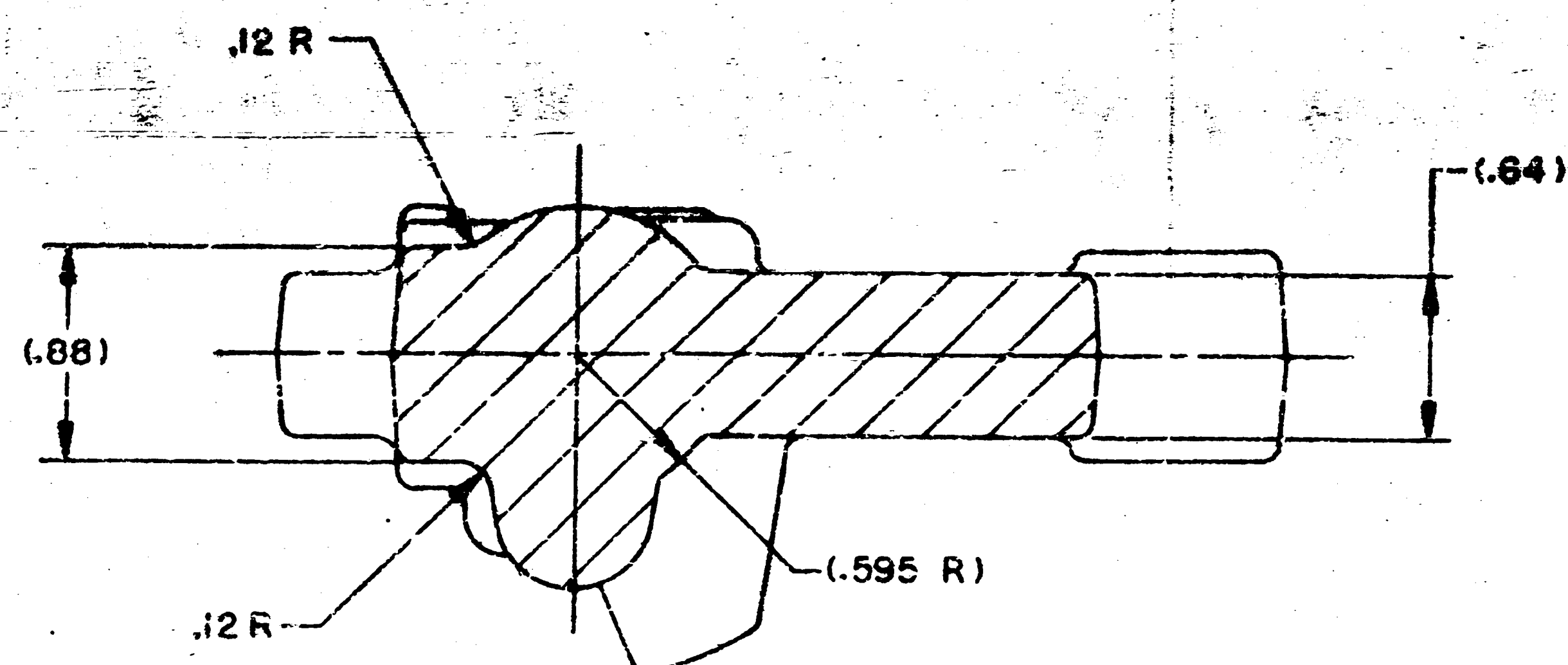
1947 FEB 1



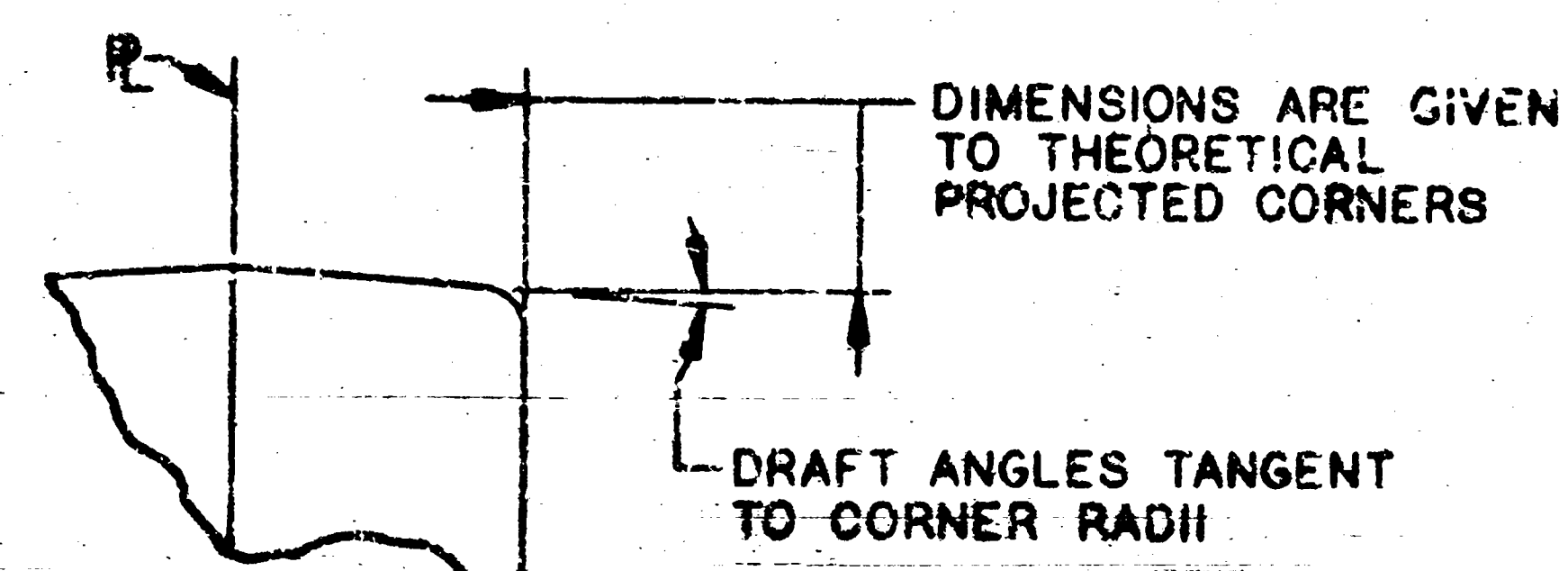
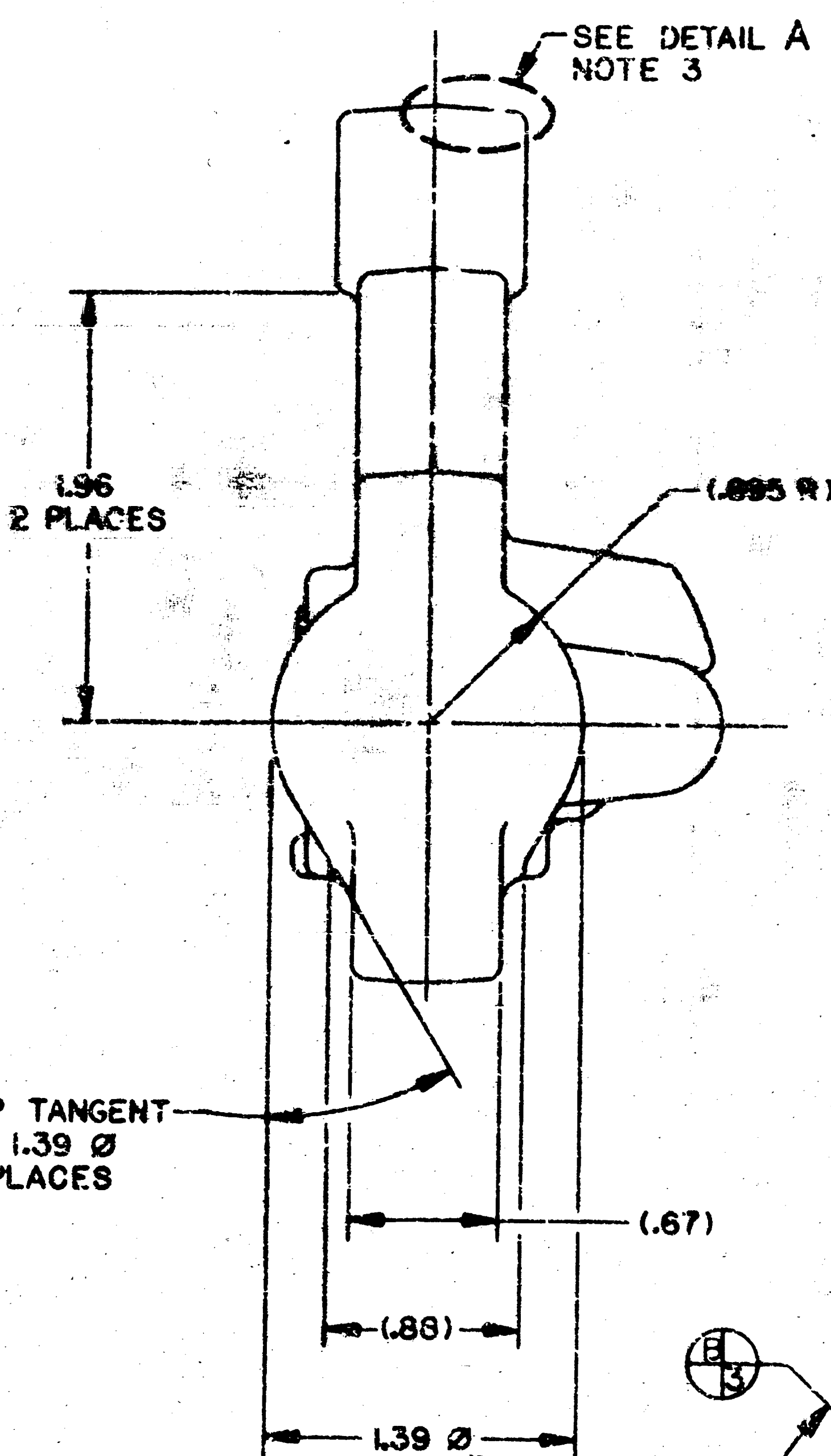
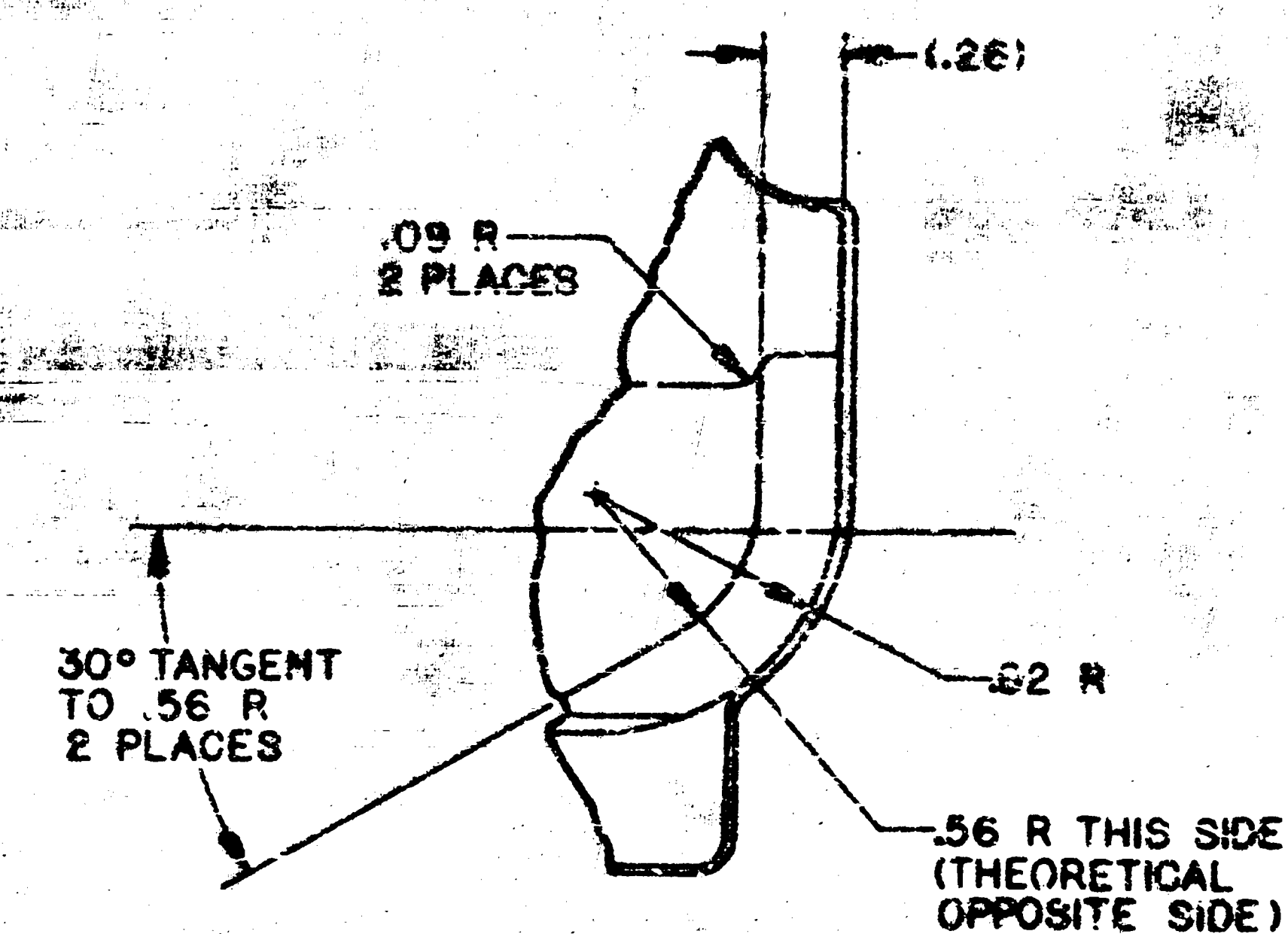
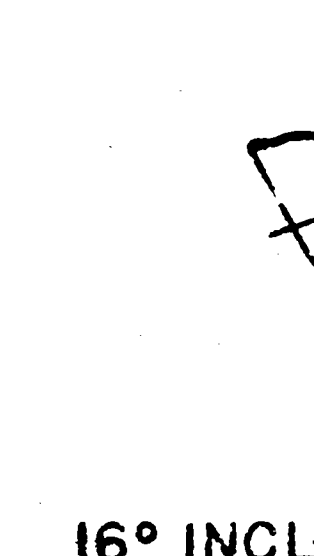
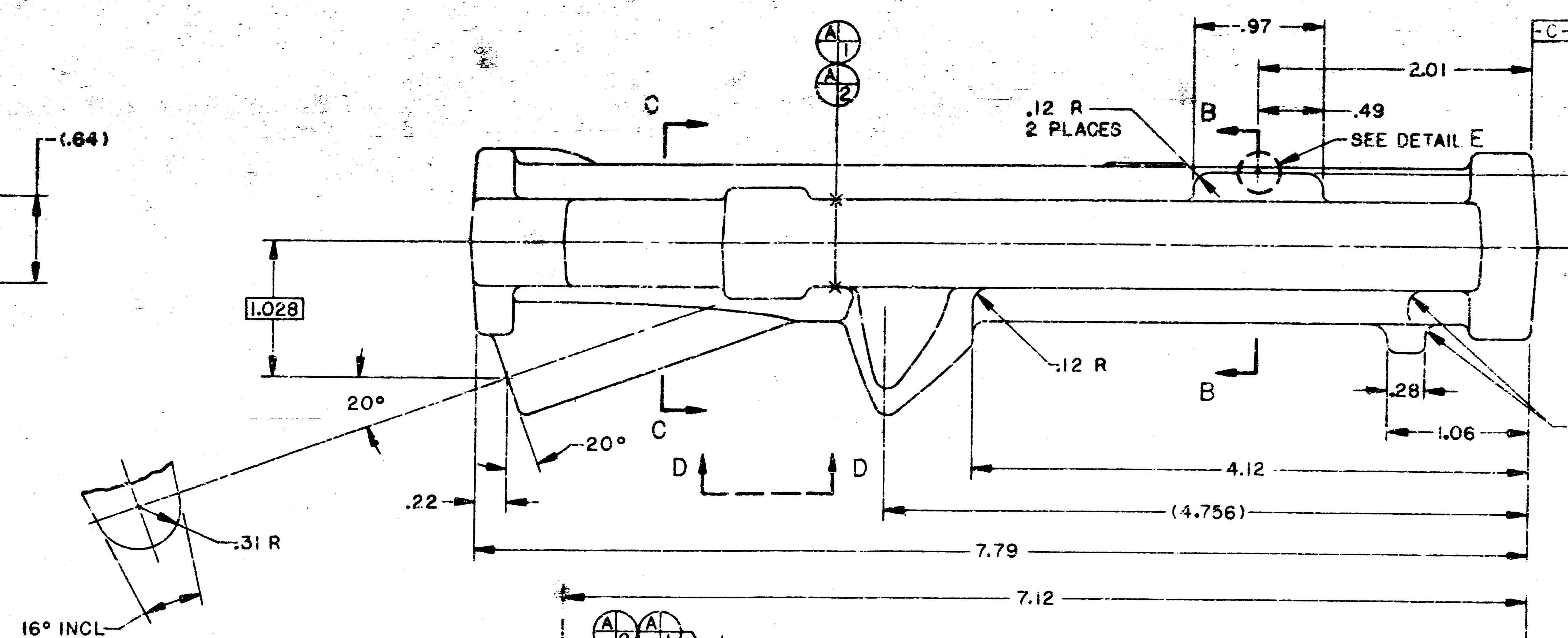
F-3 / 3



- 1—SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
- 2—MATERIAL—ALUMINUM ALLOY 7075, FORCE PER SPEC. QQ-A-362 TO COND T6. MIN BRINELL HARDNESS 135 @ 500 KG LOAD.
- 3—ALL DIMENSIONS ARE GIVEN TO THEORETICAL SHARP CORNERS. SEE DETAIL A.
- 4—4° MAX DRAFT ANGLE UNLESS OTHERWISE NOTED.
- 5—CORNER RADII .05+.03 UNLESS OTHERWISE NOTED.
- 6—FILLET RADII .08-.03 UNLESS OTHERWISE NOTED.
- 7—FLASH EXTENSION .03 MAX.
- 8—MISMATCH .020 MAX.
- 9—ALL DIMENSIONS ± .020 UNLESS OTHERWISE NOTED.
- 10—ALL ANGLES ± 0°30' UNLESS OTHERWISE NOTED.
- 11—DIMENSIONED RADII TO BE $^{+.02}_{-.01}$ UNLESS OTHERWISE NOTED.
- 12—ALL DIMENSIONS $\varnothing \varnothing .020(S)$ TO THE PLANES ESTABLISHED BY THE \varnothing [A] (G-7) AND THE \varnothing [B] (A-12).
- 13—CONICAL ABOUT \varnothing OF [B]. SEE SECTION F-F.
- 14—MARK VENDOR'S IDENTIFICATION SYMBOL .125±.015 HIGH, RAISED .025±.015.
- 15—MARK WEAPON MANUFACTURER'S IDENTIFICATION SYMBOL .125±.015 HIGH, RAISED .025±.015.
- 16—DIE NUMBER MANDATORY IN THIS AREA. ADDITIONAL VENDOR MARKINGS OPTIONAL.
- 17—FORGING MUST BE FREE OF BLEMISHES CAUSED BY ROUGH HANDLING DURING FABRICATION.
- 18—FINISH ^{125/}✓ ALL SURFACES, EXCEPT AS NOTED.



SECTION C-C

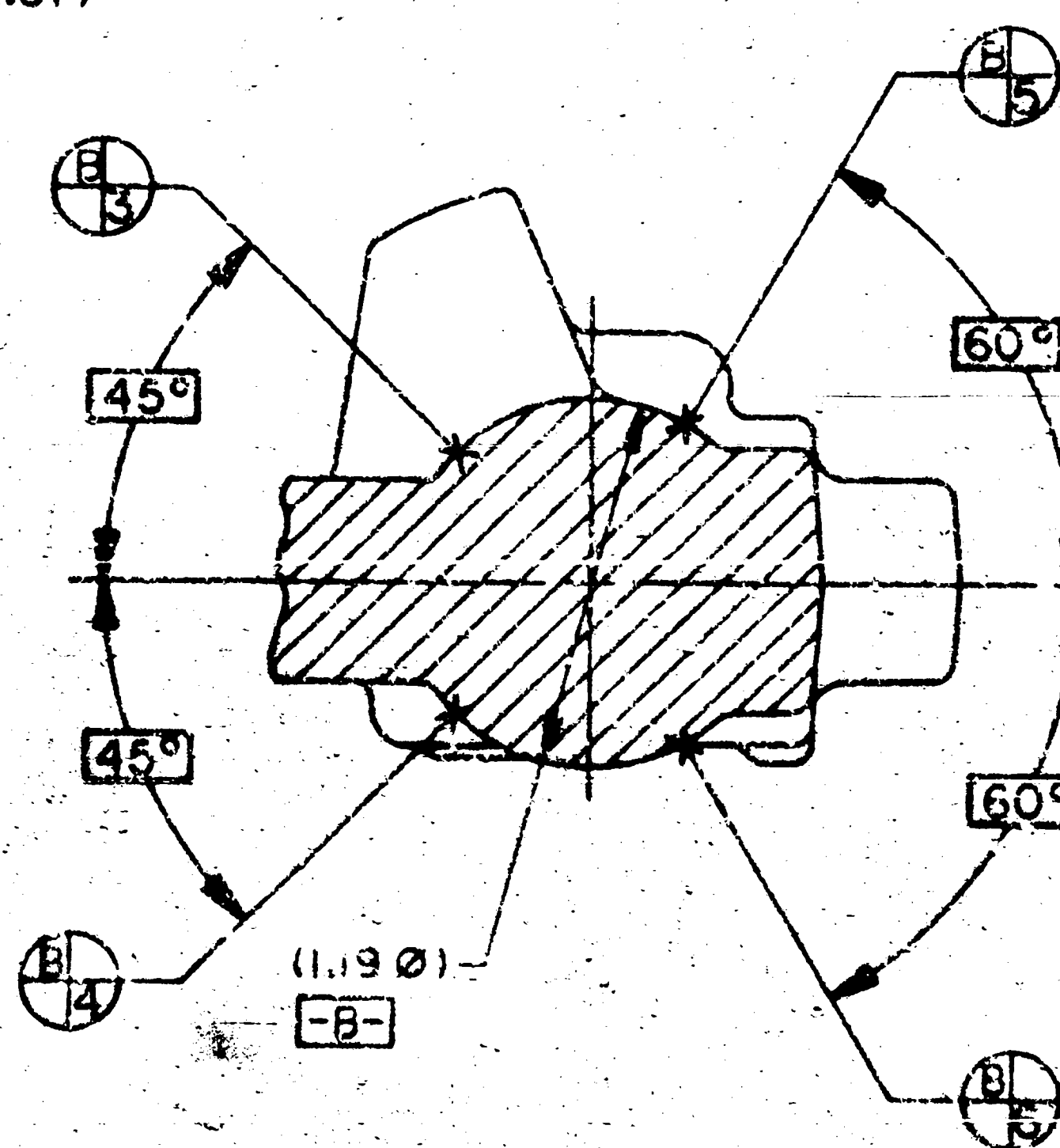


DETAIL A
SCALE: 4/1
NOTE 3

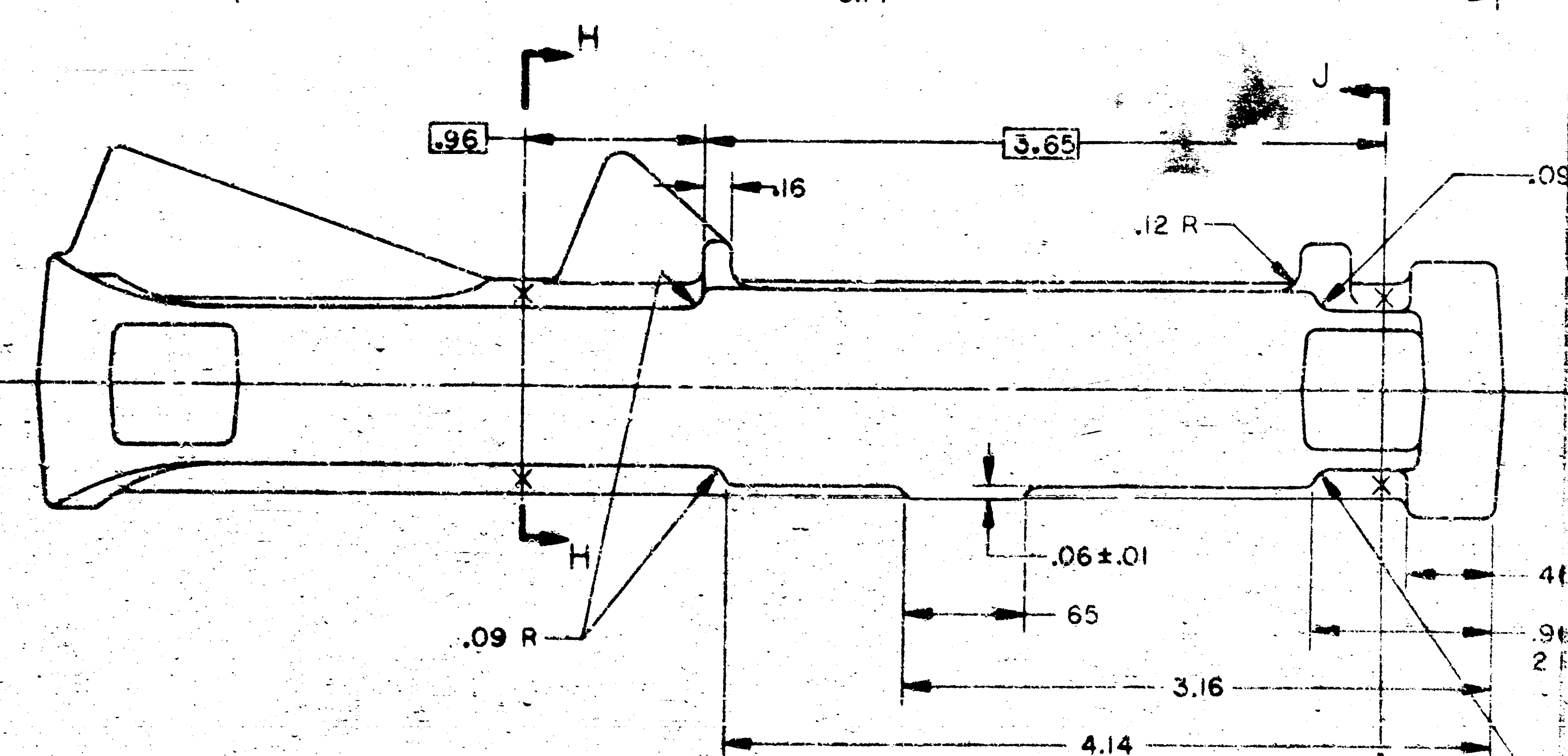
J 9 3 4 9 0 6 4

REV D SH. 1

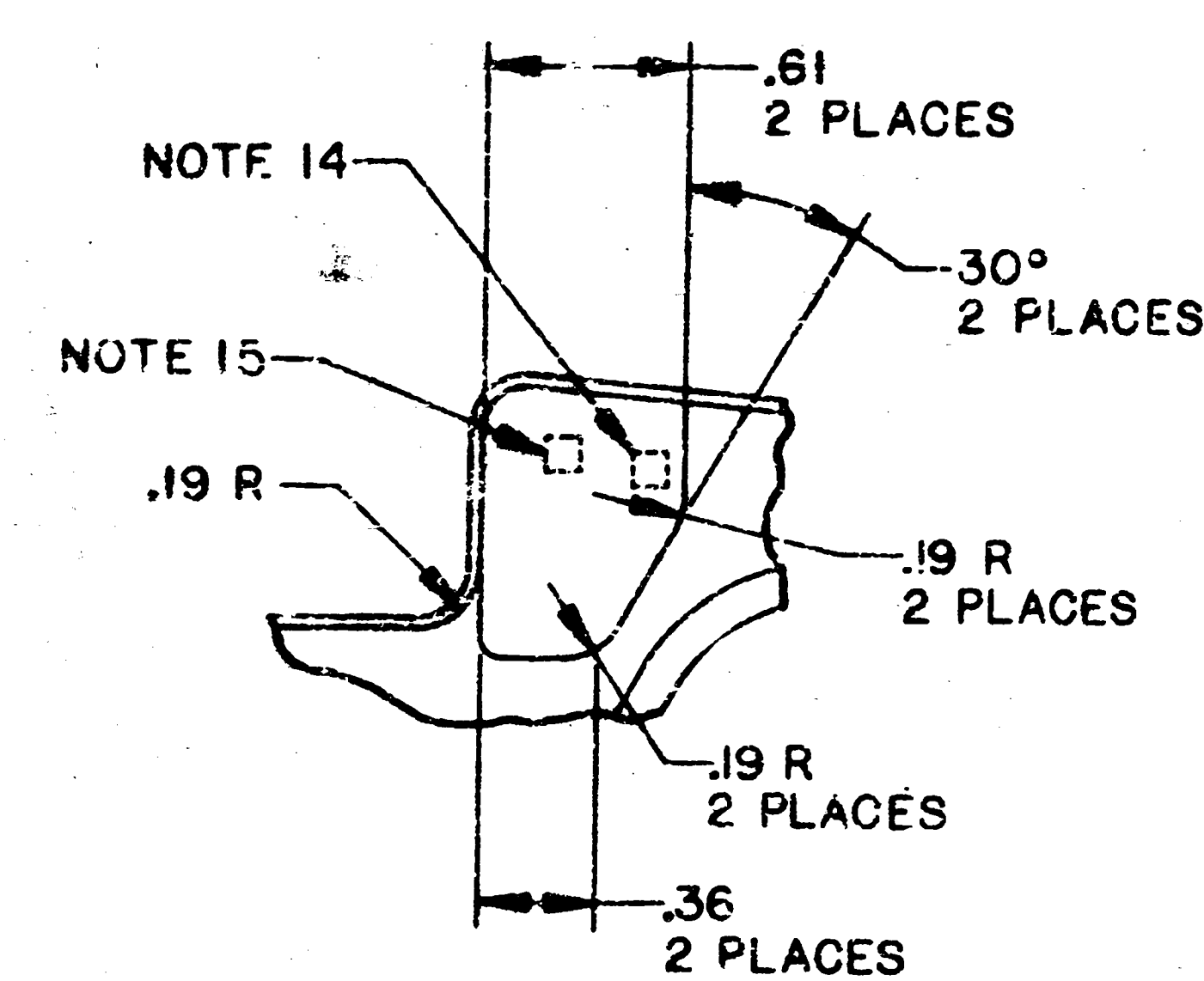
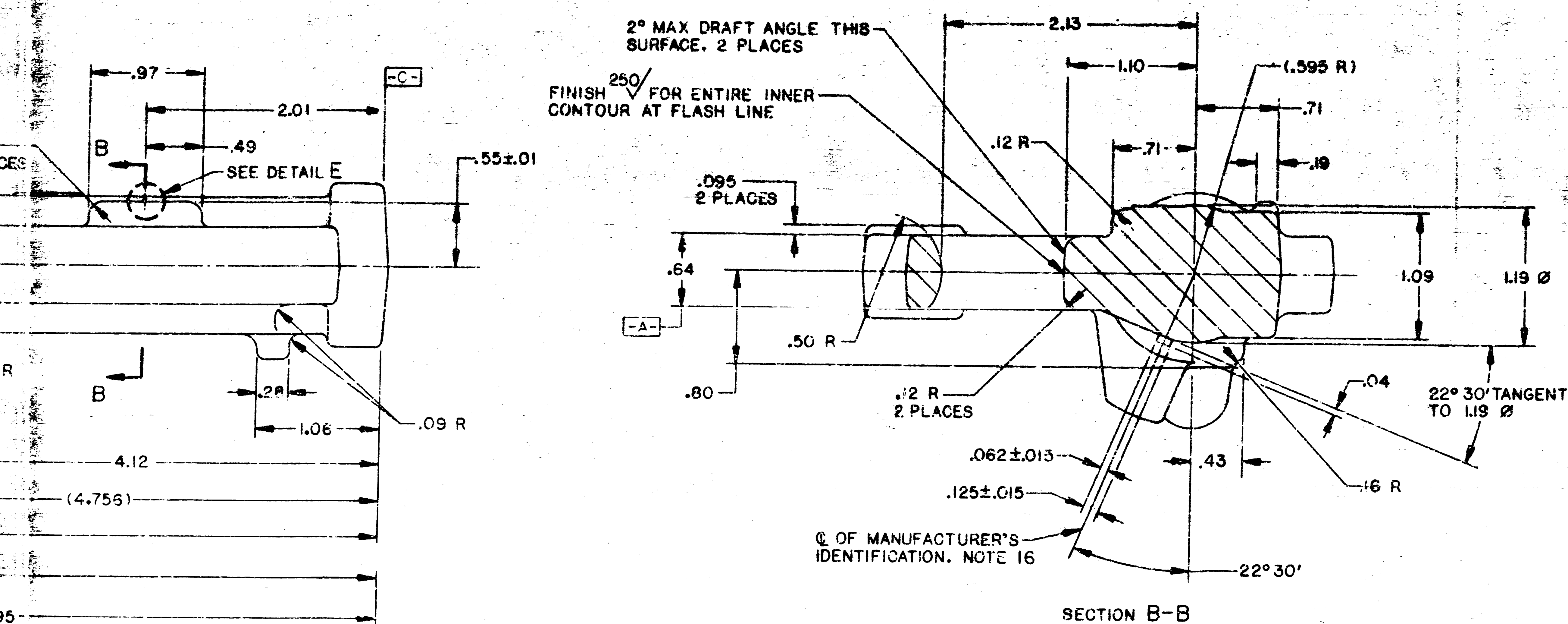
F 1 2



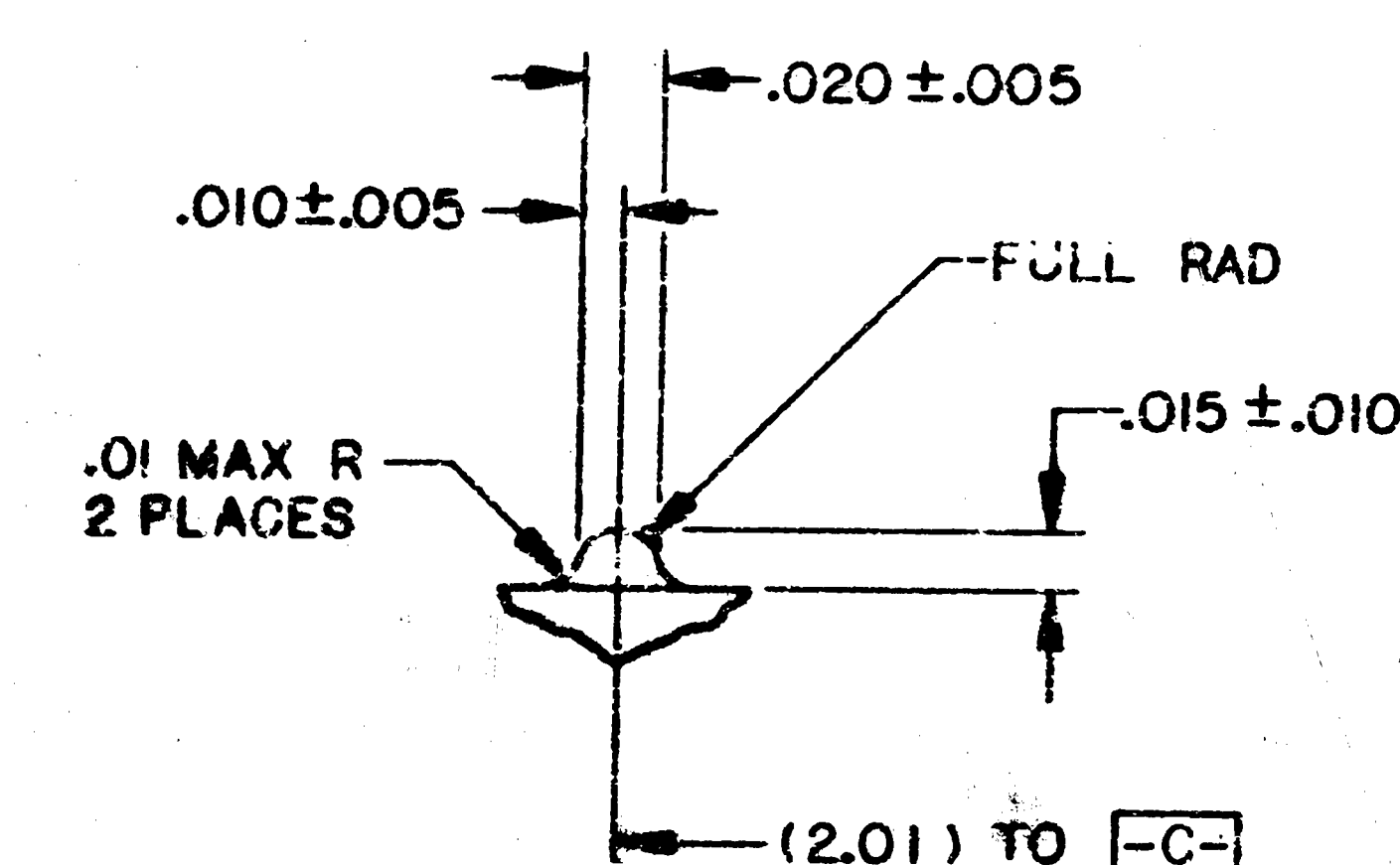
SECTION H-H



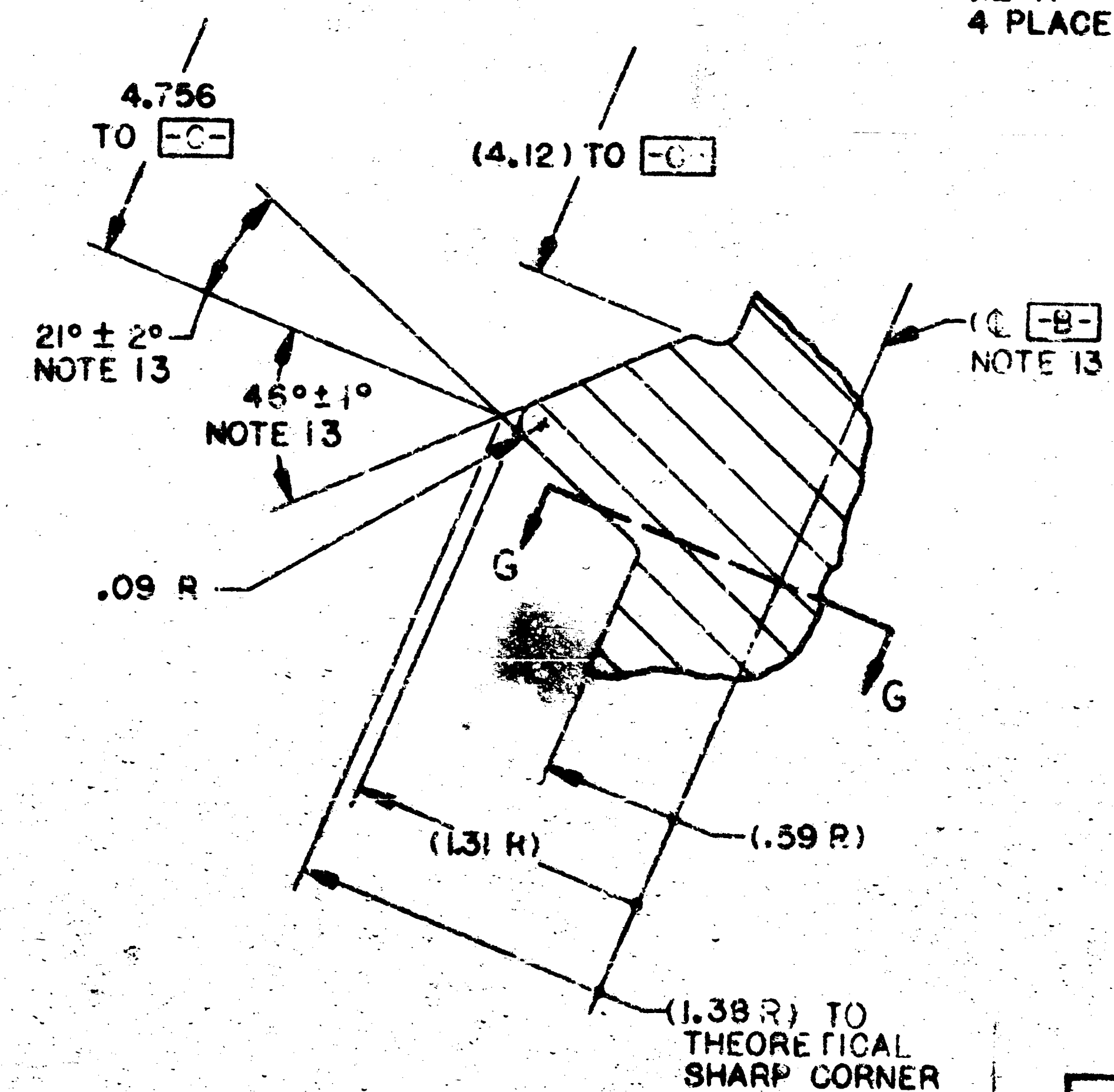
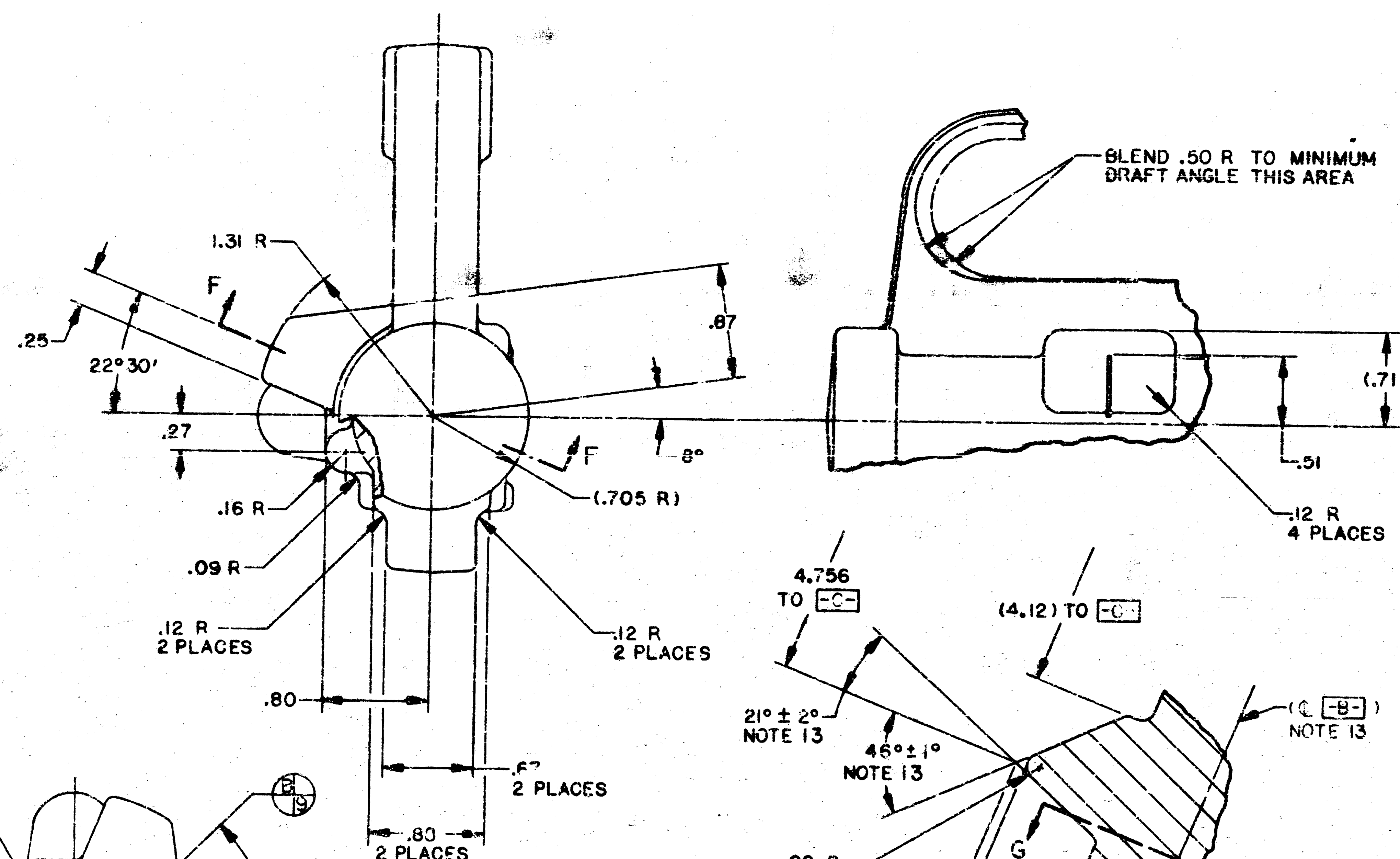
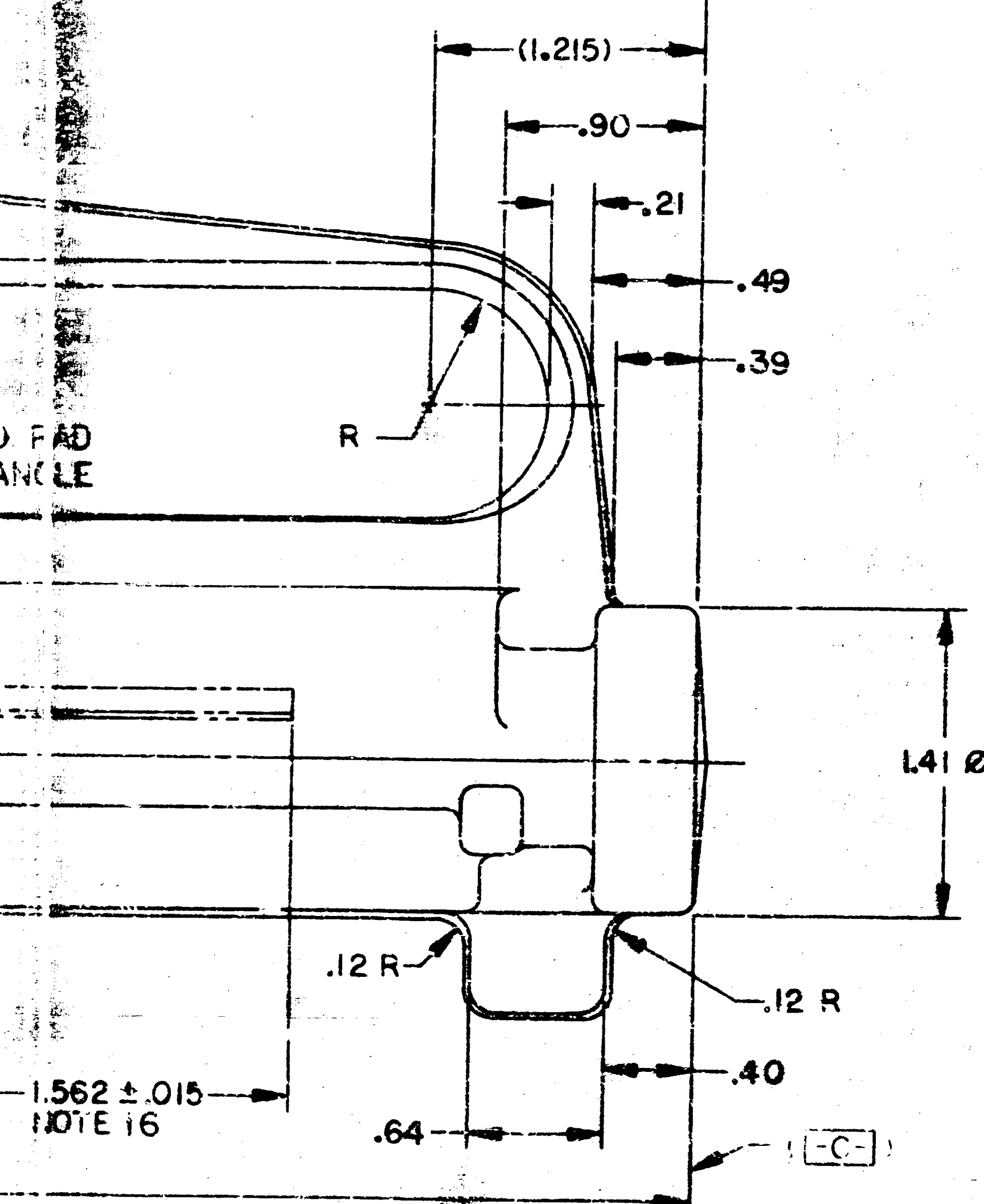
A vertical scale bar with segments labeled A through G. Segment A is at the bottom, followed by B, C, D, E, F, and G at the top. Segment B contains the number 9745064. An arrow points to the boundary between segments D and E.



VIEW D-D



DETAIL E
SCALE 20/1

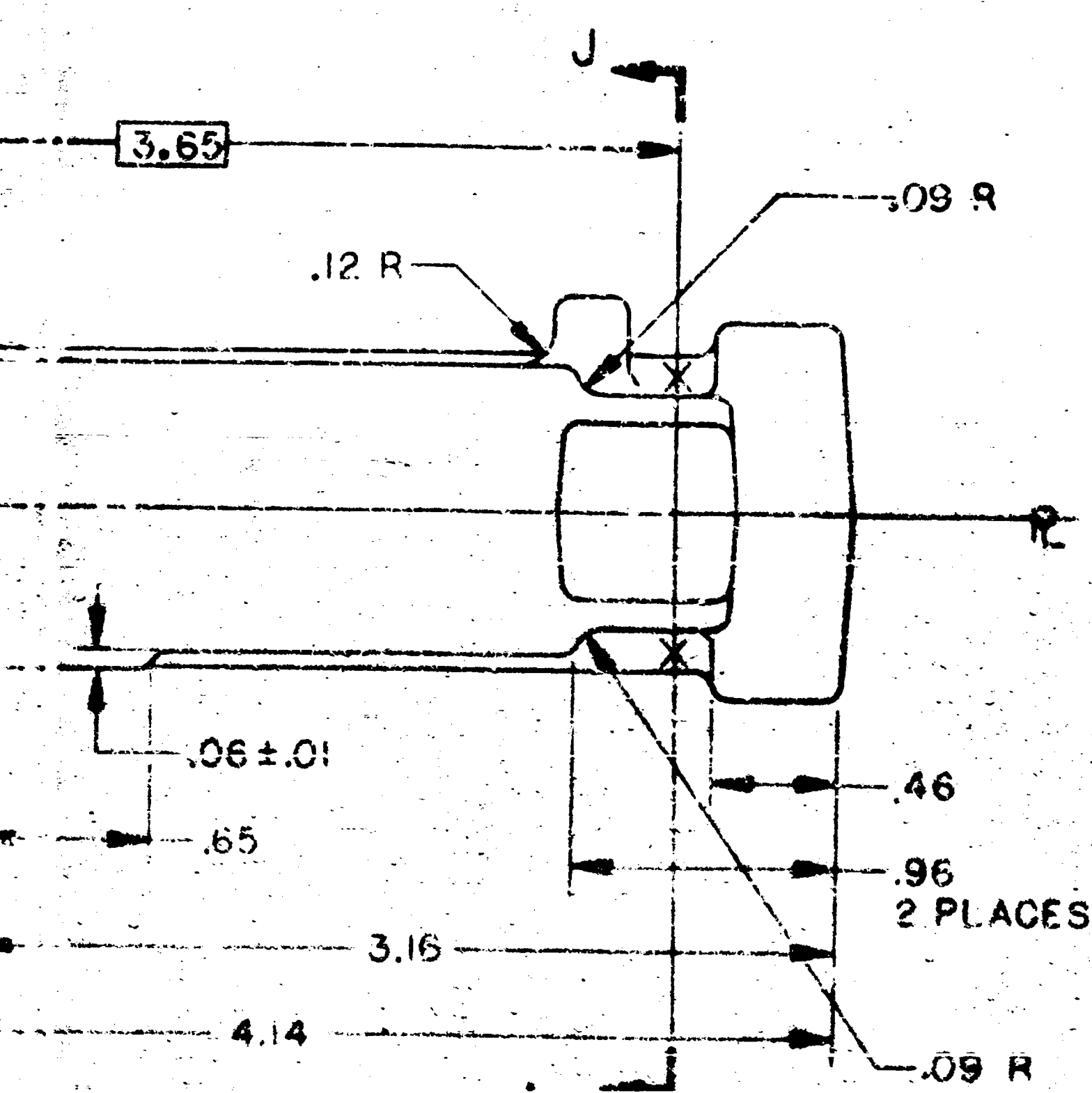


SECTION G-G

J 9 3 4 9 0 6 4



REV D SH, 1

F 2 / 2



SECTION J-J

SECTION F-F

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 02-06-09		PART NO. 9349064 U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER DOWRY NEW JERSEY 07001	
YD		TS		TOLERANCES ON DECIMALS 2		DRAWN BY	SMI	CHECKED	JWH
ELV		RA		FRACTIONS 2		ENG		FRSH	
				HOLE SIZES 2		ENG		ENG	
0349064	M16A2	RM				 		UPPER RECEIVER FORGING	
U.S. ARMY	USED ON	RTY						N/A J	FSCM NO. 19200
APPLICATION						SCALE 2:1 UNIT WT		SHEET 1 OF 1	

THIS INVOICE DOCUMENT AND ALL INFORMATION THEREON IS PROPRIETARY TO CELYTO INC AND SHALL NOT BE REPRODUCED, COPIED, CITED OR IMPARTED IN WHOLE OR IN PART, DISCLOSED OR MADE AVAILABLE TO ANY OTHER PERSON, FIRM OR ORGANIZATION WITHOUT THE WRITTEN CONSENT OF THE CLIENT NECESSARY FOR AND THEN ONLY IN CONNECTION WITH THE PERFORMANCE OF CELYTO INC'S OBLIGATIONS OF WORK OR PERFORMANCE RELATED TO A PERFORMANCE TASKS ASSIGNED BY THE UNITED STATES GOVERNMENT OR A SUB-CONTRACTOR UNDER THE TRANSFERENCE IN THE UNITED STATES EITHER BY THE UNITED STATES GOVERNMENT OR UNDER A CONTRACT WITH THE UNITED STATES GOVERNMENT. THIS DOCUMENT IS NOT TO BE USED FOR ANY OTHER PURPOSES AND IS NOT TO BE REPRODUCED OR DISCLOSED TO ANY OTHER PERSON, FIRM OR ORGANIZATION WITHOUT THE WRITTEN CONSENT OF CELYTO INC. THE UNITED STATES GOVERNMENT OR A SUB-CONTRACTOR UNDER THE TRANSFERENCE IN THE UNITED STATES EITHER BY THE UNITED STATES GOVERNMENT OR UNDER A CONTRACT WITH THE UNITED STATES GOVERNMENT. THIS DOCUMENT IS NOT TO BE USED FOR ANY OTHER PURPOSES AND IS NOT TO BE REPRODUCED OR DISCLOSED TO ANY OTHER PERSON, FIRM OR ORGANIZATION WITHOUT THE WRITTEN CONSENT OF CELYTO INC.

1 - SPEC. MIL-W-13855 AND ANSI Y14.5-73
APPLY.

2 - MATERIAL :- HAMMER CASTING - 9349112.

3- ALL DIMENSIONS APPLY WHEN LOCATED ON
[F] AND [G].

4 - ALL DIM. EXCEPT THOSE DEFINING C ARE BEFORE FINAL PROTECTIVE FINISH.

5-SURFACES SO NOTED //F.001

6-BREAK SHARP EDGES .005 +.010 UNLESS OTHERWISE NOTED.

7 - FILLET RADIUS .015 - .012 UNLESS OTHERWISE NOTED.

8 - GRIND ☐ AFTER HEAT TREAT AND FINAL PROTECTIVE FINISH, DIRECTION OF GRIND ☐. MAX METAL REMOVED BY GRINDING .005.

9 - HEAT TREATMENT: - CARBURIZE, CASE DEPTH .014
TO .018 TOTAL. CASE HARDNESS EQUIV. TO RH 30M
75 TO 79.

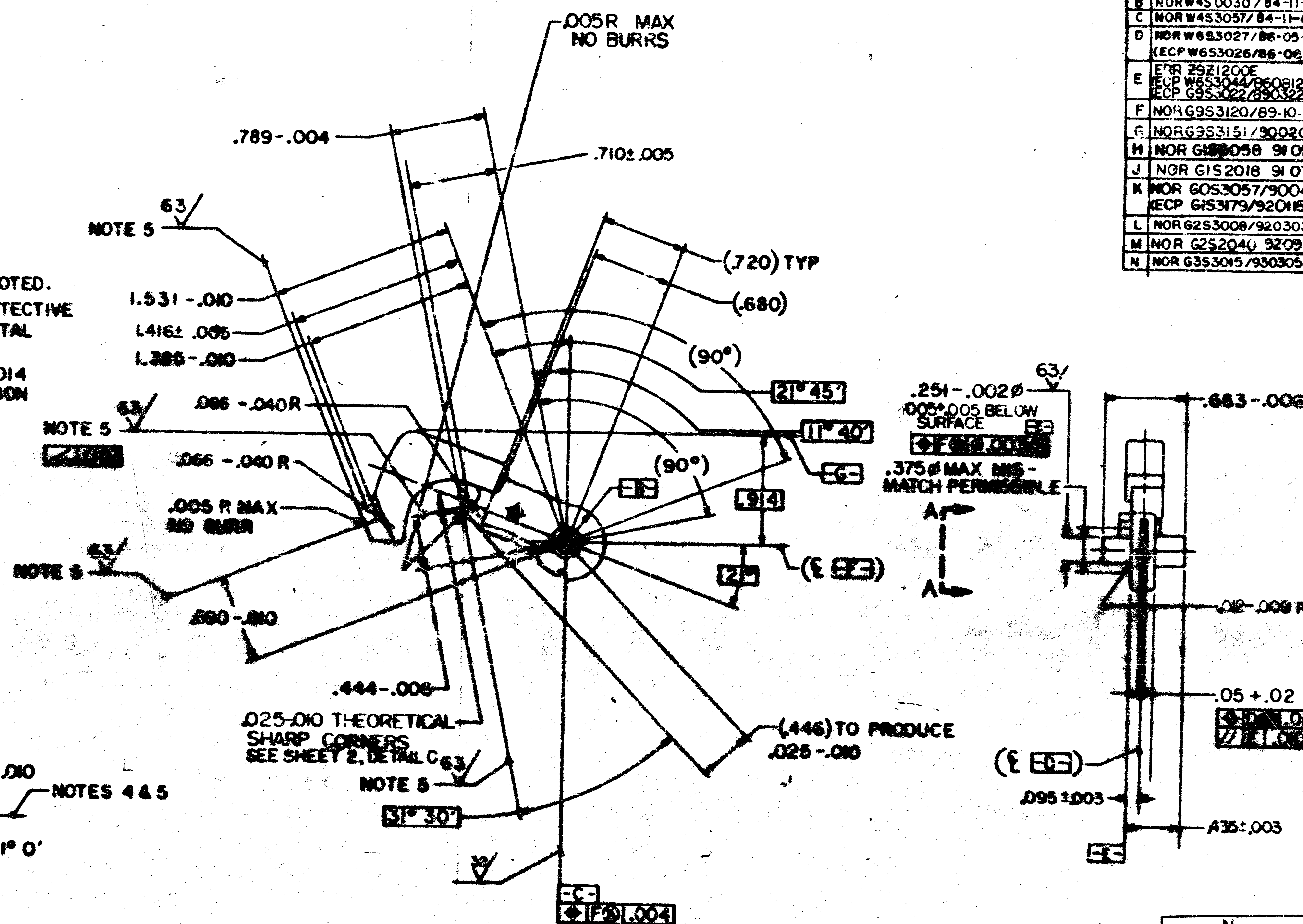
10-FINISH ¹²⁵✓ ALL SURFACES EXCEPT AS NOTED.

11-COAT GROUND SURFACE [C] WITH CORROSION
RESISTING OIL PER MIL-L-48000A.

12-PROTECTIVE FINISH:- 5.3.1.2 OF MIL-STD-171



DESTROYING IT MEANS IT FURTHER DESTROYED ONLY AS
 DESTROYED IN 1968, 1969-1970, ROCK ISLAND, I.
 100-44-1000



RENTAL			
QTY	DESCRIPTION	DATE	APPROVAL
A	PRODUCTION RELEASE ERRW52013	820614	8/28/82
B	NORW353160/83-12-22	840618	8/28/82
B	NORW450030/84-11-15	850402	8/28/82
C	NORW453057/84-11-07	850520	8/28/82
D	NORW683027/86-05-28 (ECPW653026/86-06-18)	870828	8/28/82
E	ERR 2521200E ECP W653044/850812 ECP 6353022/850322	880116	8/28/82
F	NOR6935120/89-10-26	90-03-30	8/28/82
G	NOR6935151/900205	901011	8/28/82
H	NOR G180058 910521	91 07 23	8/28/82
J	NOR G152018 91 07 08	91-10-11	8/28/82
K	NOR 6053057/900423 (ECP G153179/920115)	920227	8/28/82
L	NOR 6253008/920303	920331	8/28/82
M	NOR G25204/ 920915	921106	8/28/82
N	NOR G353045/930305	931006	8/28/82

N	N
SH 2	SH 1
REVISION STATUS OF SHEET	

PART NO. 934911

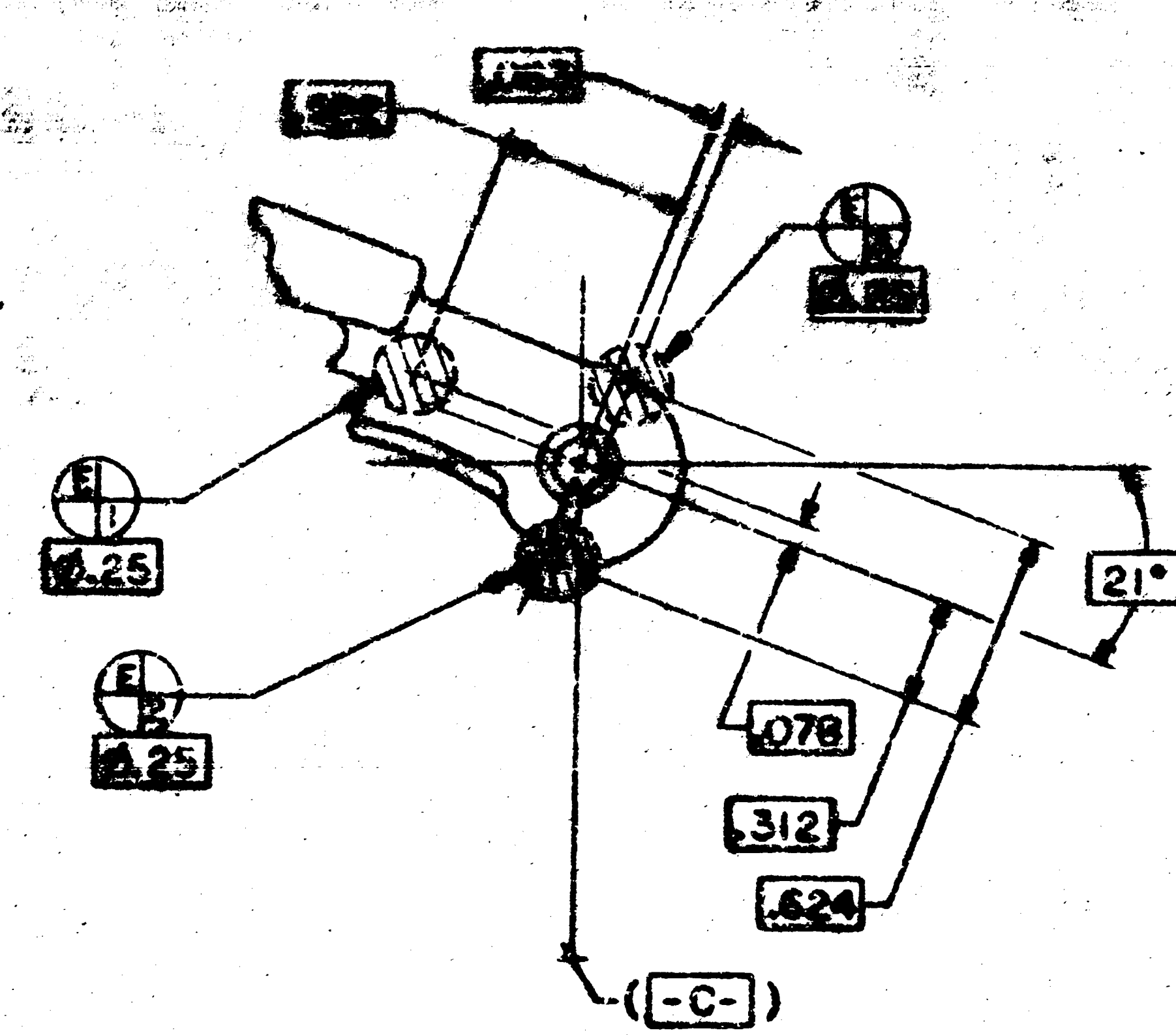
U.S. AIR FORCE RESEARCH AND DEVELOPMENT CENTER
WRIGHT-PATTERSON AIR FORCE BASE, OHIO 45433

HAMMER

SIZE D	FSC# NO. 19200	9349111
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PAGE 2 / COST WT. SHEET OF 2

EXPENSE			
QTY	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE 52W252013	820614	PLA
A	NORW353160/83-12-22	840618	PLA
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C	NORW453057/84-11-07	850626	PLA
D	NORW653027/84-02-26	870218	PLA
F	NOR 6953182/89-10-10	90-03-30	PLA
G	NCRG953151/900205	901011	PLA
L	NOR 6253008/920303	920331	PLA
M	NOR 6252040 920915	921106	PLA
N	NOR 6253015/930305	930405	PLA

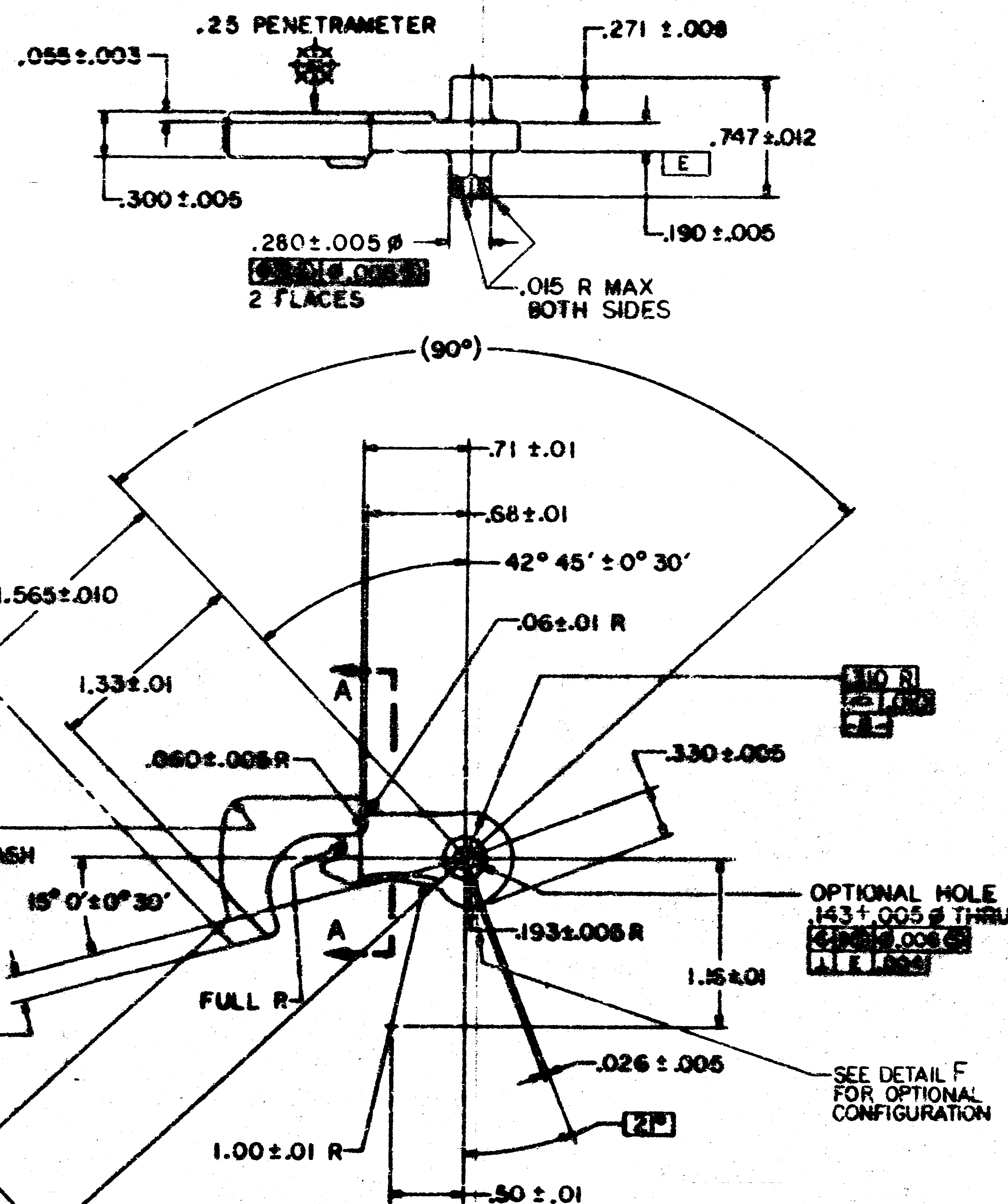
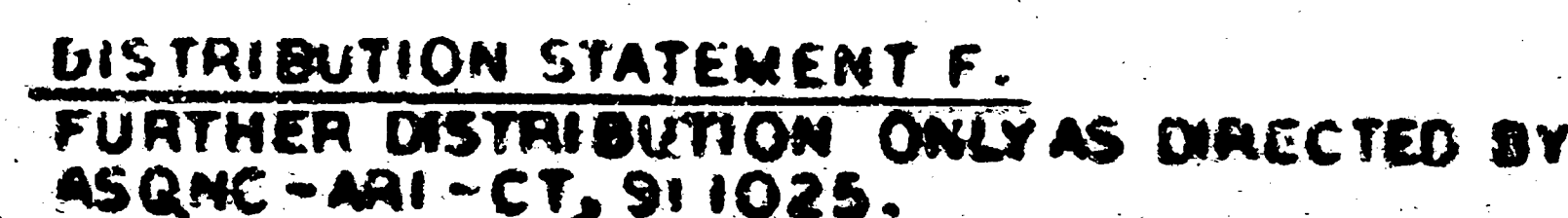


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ASDNC-AR: 911923

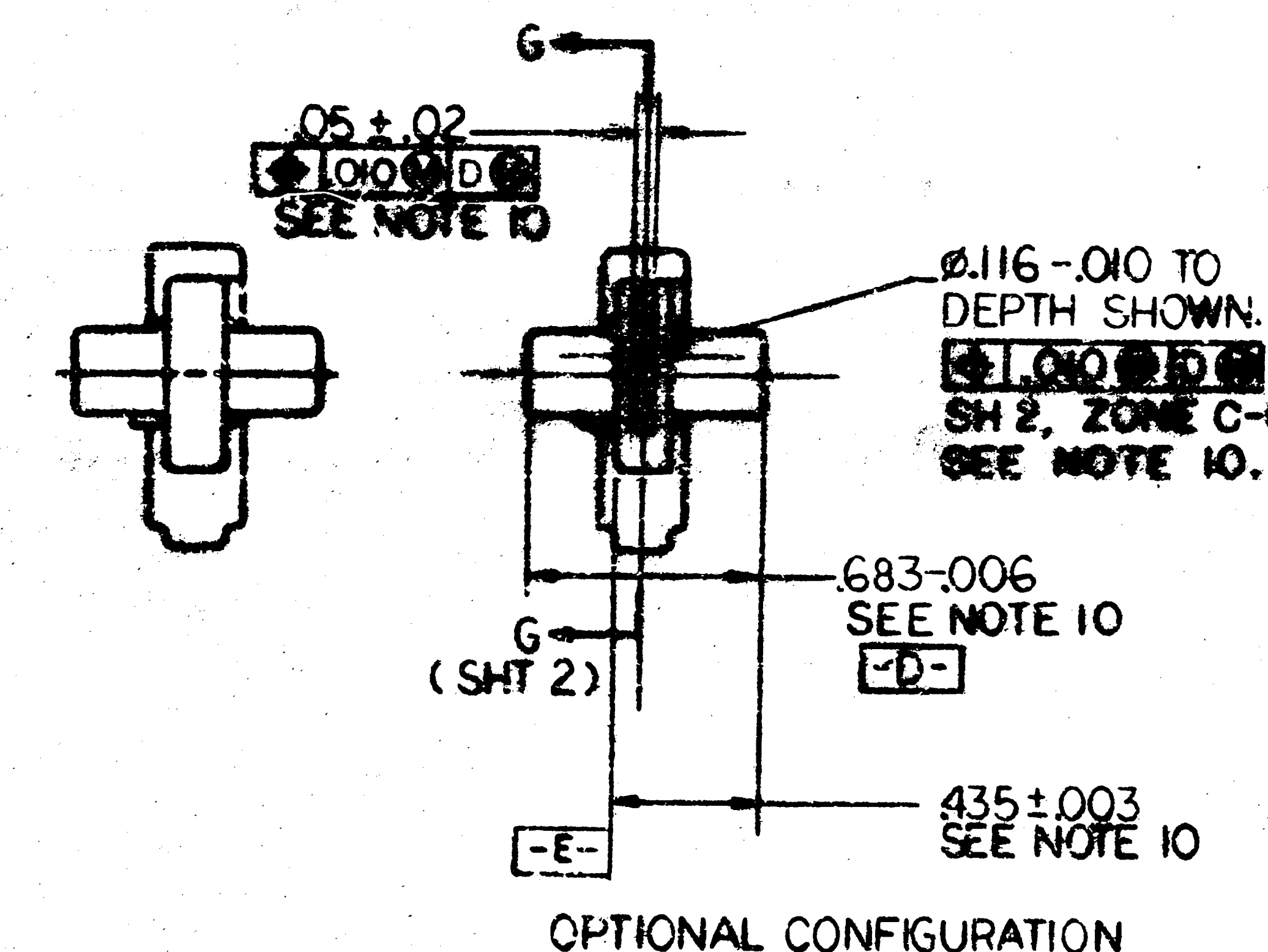
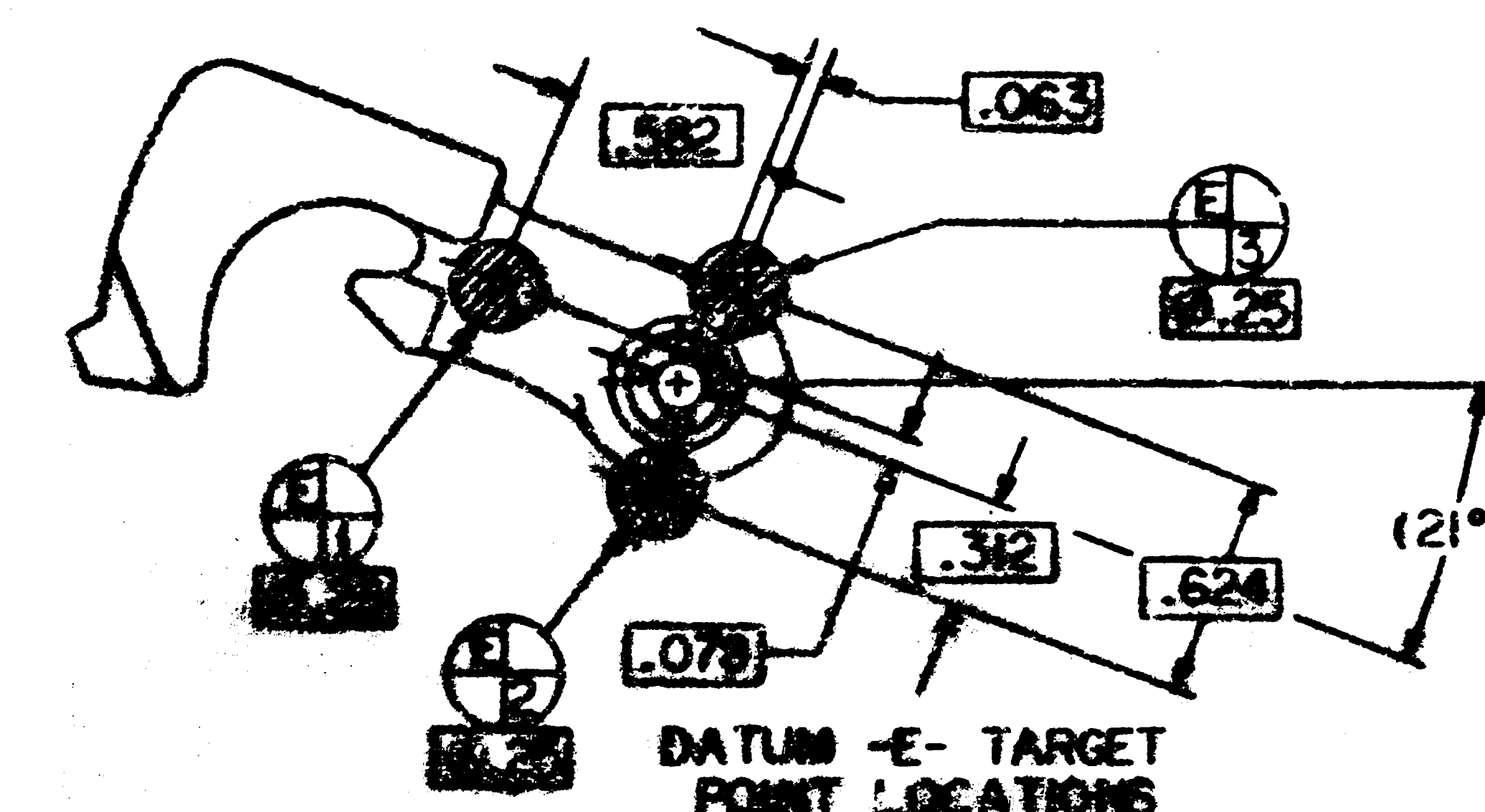
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		NAME OF ORGANIZATION		HAMMER	
		ADDRESS (Street, P.O. Box, etc.)		FSCM NO. 19200	
		CITY, STATE, AND ZIP		9349111	
		COUNTRY		PAGE 2 OF 2	
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NOTES : —

- Ø .156-.008 THRU
 ◆ Ø .006 SPS
 L .004 C
 SEE NOTE 10



REVISIONS			
S/N	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRW252013	820614	
A	NOR W35 3161 / 83-12-22	840619	PK 20
B	NOR W450030 / 84-11-15	850402	PK 20
C	NOR W433057 / 84-11-07	860828	PK 20
D	NOR WSS3026 / 85-07-23 (ECP WSS2098 / 85-11-21)	860724	PK 20
E	NOR G153084 / 910708	910826	PF
F	NOR G152018 / 910708	911011	RRGL
G	NOR G153137 911001 (ECP G153144 911021)	920204	PK HL
H	NOR G353073 930617	931110	PK



G	H
SH 2	SH 1
REVISION STATUS OF SHEET:	

PART NO. 9349112

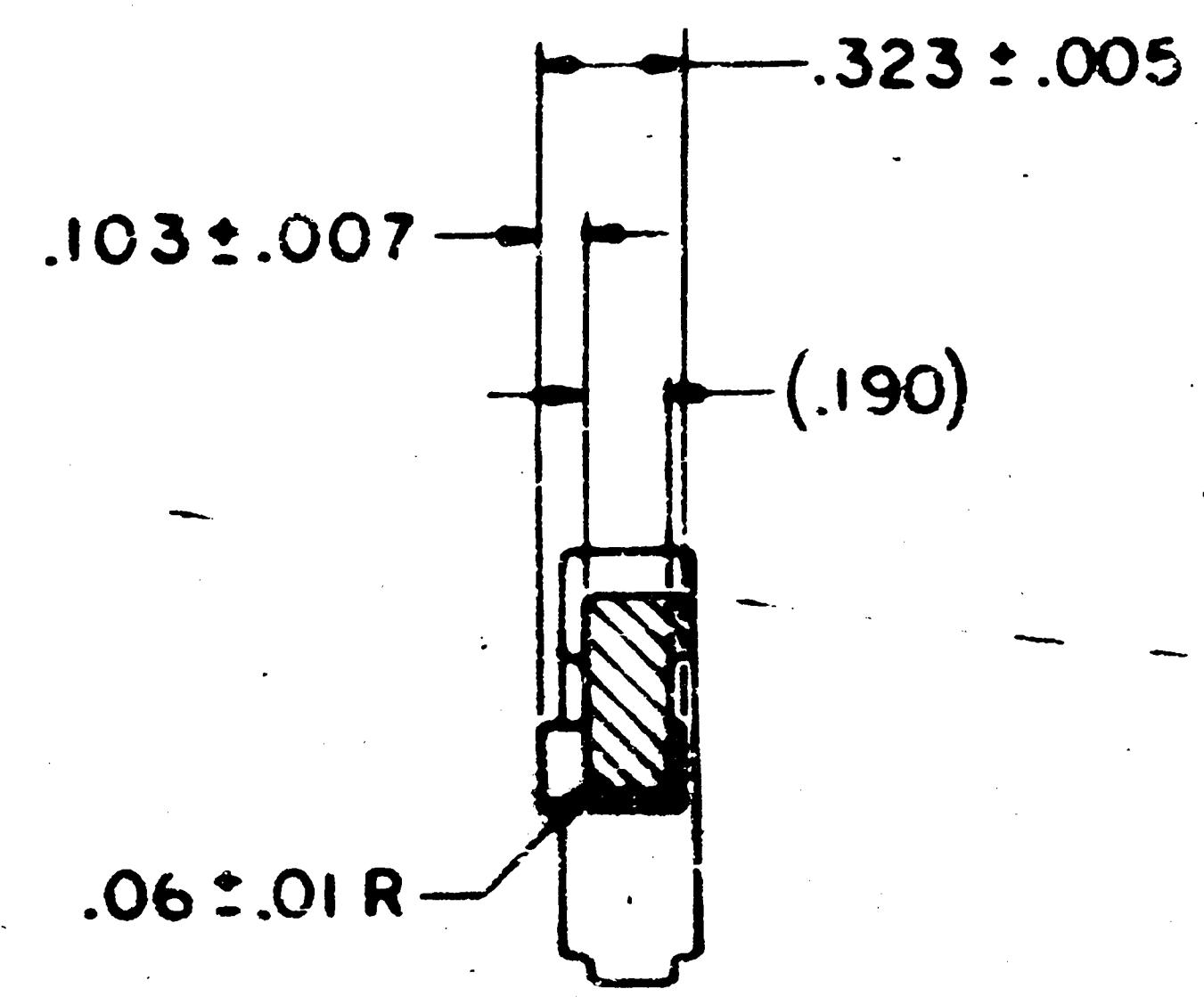
U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER FOUR, NEW JERSEY 07061			
HAMMER CASTING			
FORM D	FSCM NO. 19200	9349112	
PAGE 3/1		LINE NO.	SHEET 1 OF 2

THIS DRAWING IS UNCLASSIFIED
DATE 07-12-83 BY 1045

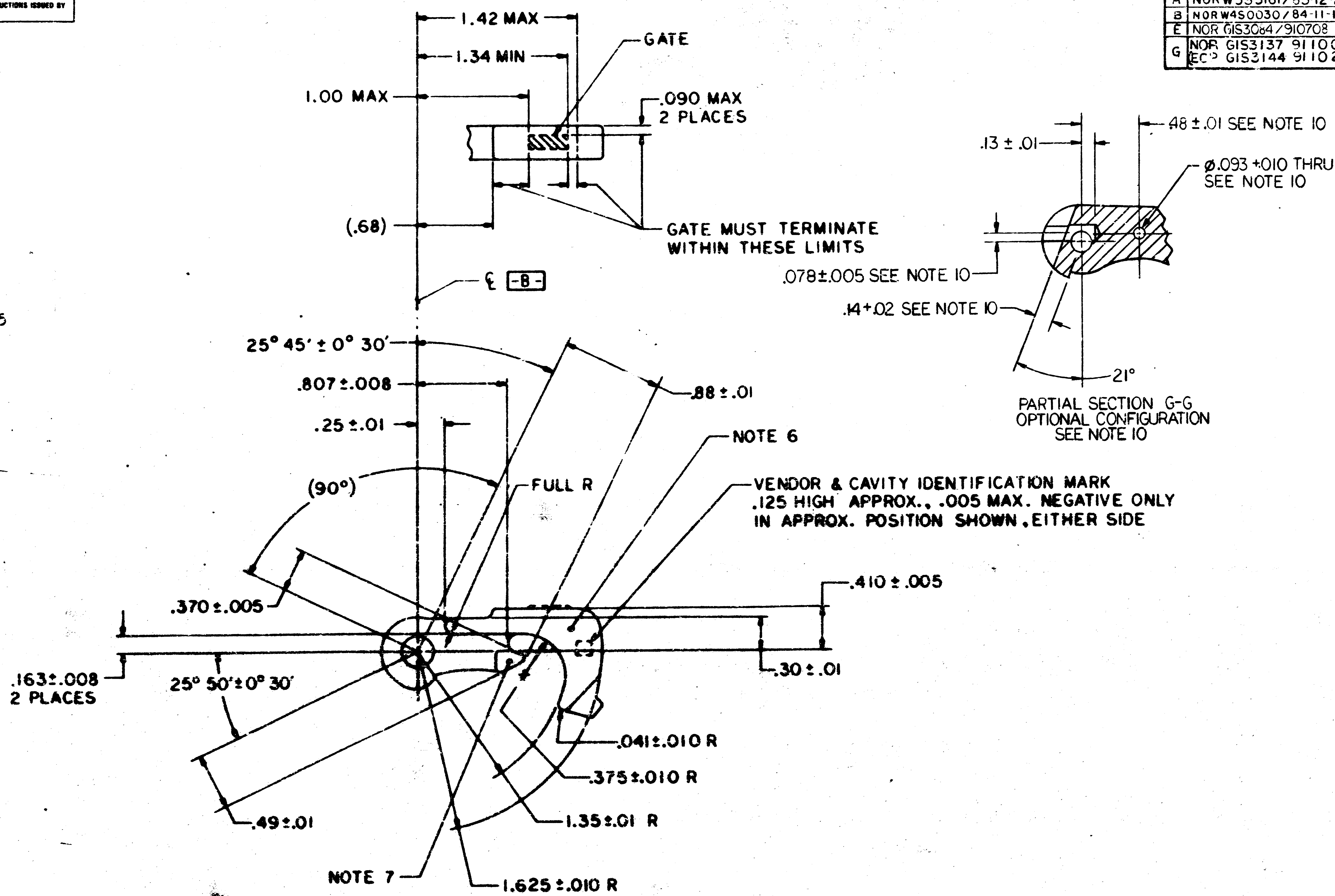
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REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
-	PRODUCTION RELEASE ERRW252013	820614	R. H. H. / J. H. H.
A	NORW353161/83-12-22	840619	R. H. H. / J. H. H.
B	NORW450030/84-11-15	850402	J. H. H. / J. H. H.
E	NOR GIS3084/910708	910826	PF / J. H. H.
G	NOR GIS3137 9110 01 EC3 GIS3144 9110 21)	920204	TH / J. H. H.



SECTION A-A



PART NO. 9349112

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DURHAM, NEW JERSEY 07801

HAMMER CASTING

FSCM NO. 19200 9349112

SCALE 2/1 UNIT WT SHEET 2

DO NOT SCALE DRAWING		GENERAL DATE OF REVISION	
UNLESS OTHERWISE SPECIFIC DIMENSIONS ARE IN INCHES		82-02-26	
FORWARDED BY SERIALS		DATE	1/1/11
REVISIONS		DATE	
MICA2		DATE	
APPROVED		DATE	

DRAWING SIZE C
(ARRADCOM 70-12)

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NOTES:-

1-SPEC MIL-W-13855 AND ANSI Y14.5-73
APPLY.

2-MATERIAL:

WIRE, STAINLESS STEEL, TYPE 631 (17-7PH),
COLD DRAWN, ASTM-A313.

3-WIRE DIAMETER:- .0200 ± .0005 .

4-DIRECTION OF HELIX:- OPTIONAL .

5-TOTAL NO. OF COILS:- (7.5)

6-LOAD AT COMPRESSED LENGTH OF
.263:- 2.1 LBS ± .21 LBS .

7-MAX. SOLID HEIGHT:- .154 .

8-BREAK SHARP EDGES .003 + .012 .

9-FINISH $\sqrt{125}$ ALL SURFACES.

10-MANUFACTURE IN ACCORDANCE WITH
TYPE I, GRADE B, MIL-S-13572,
EXCEPT PARAGRAPH 4.4.4.1 SHALL
NOT APPLY.

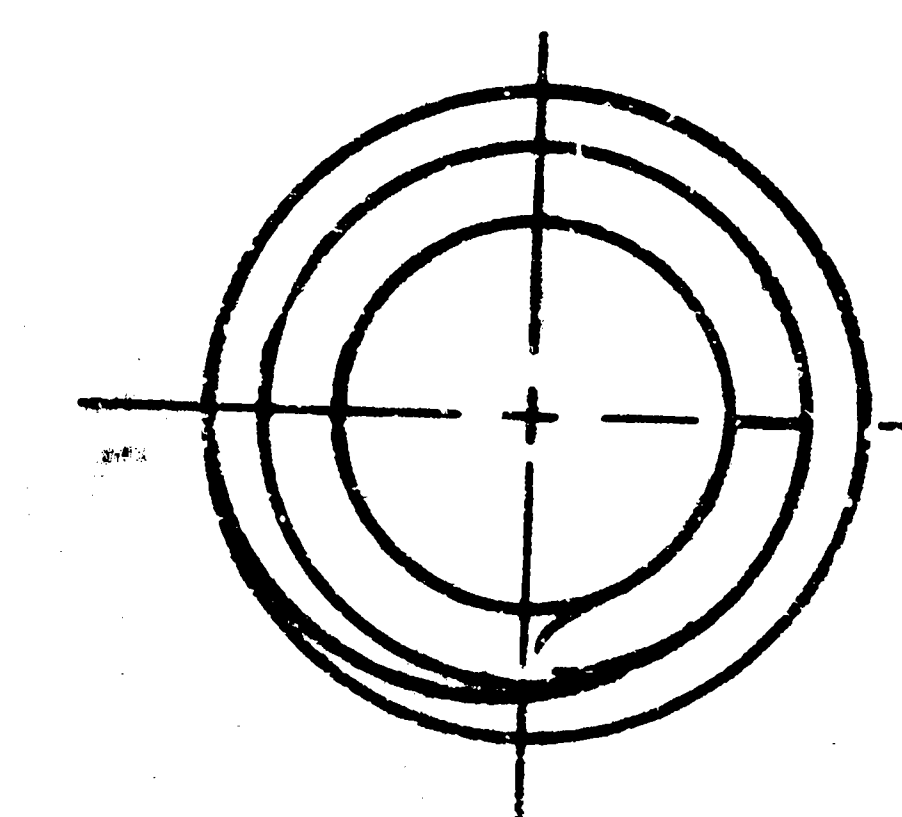
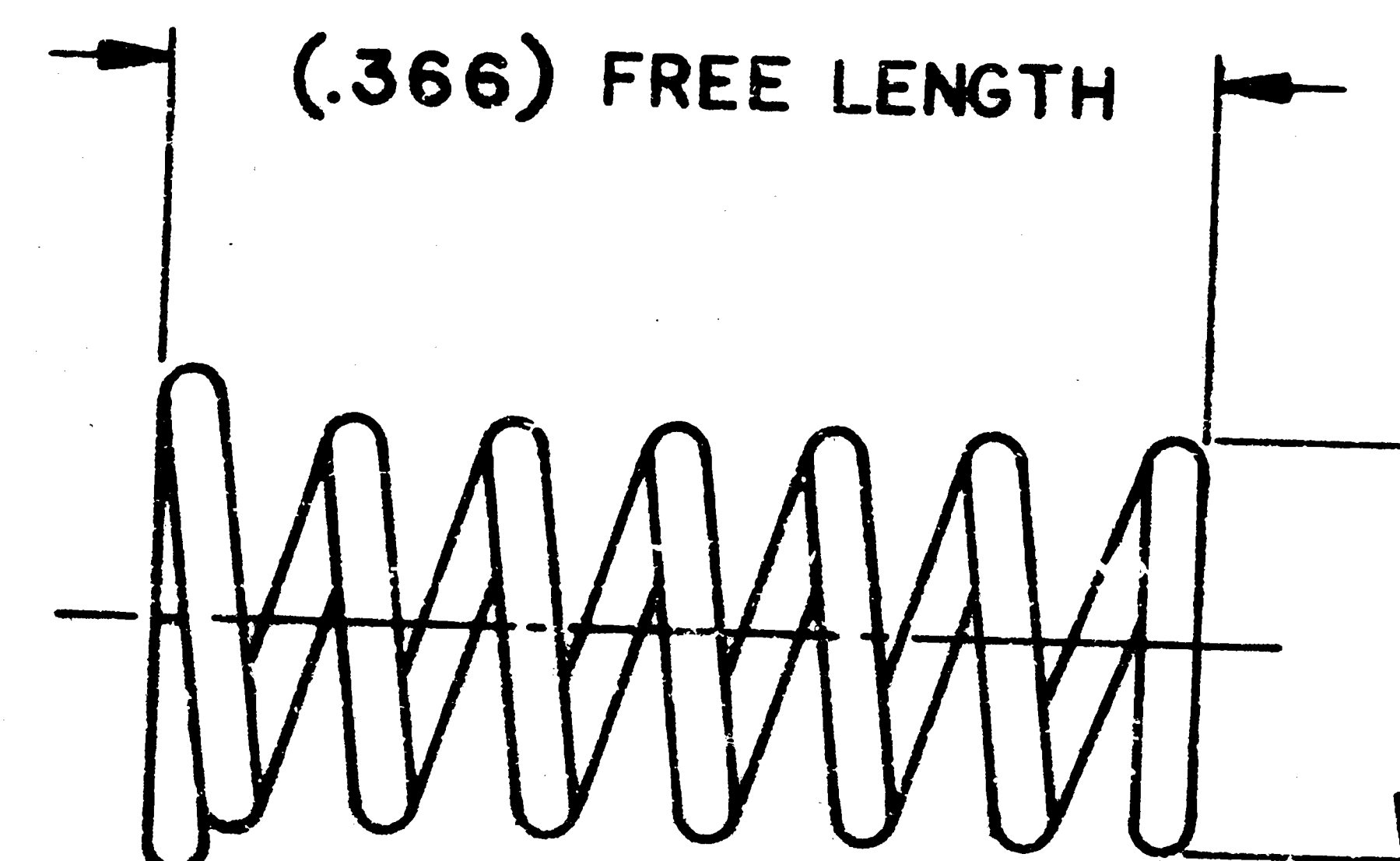
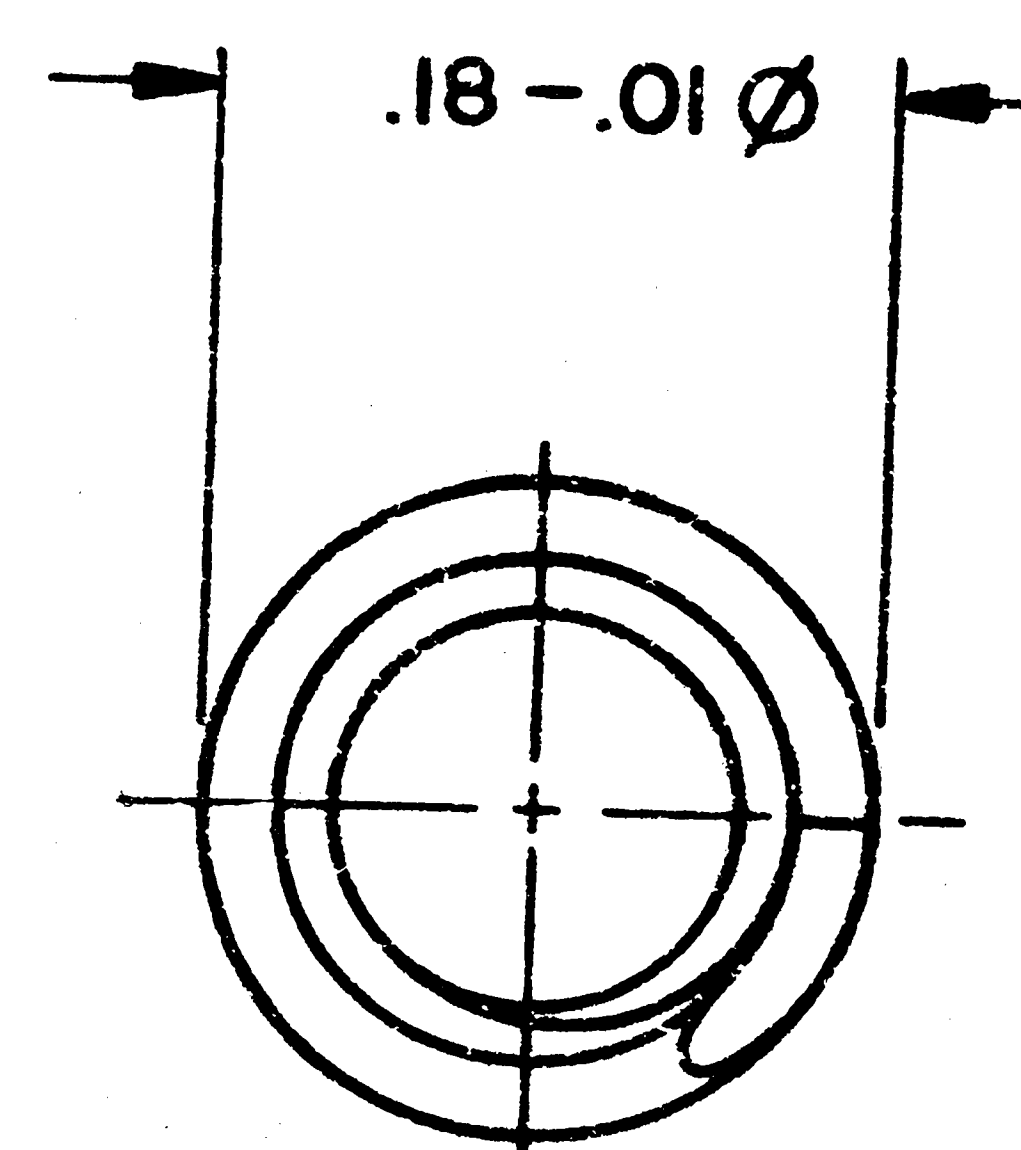
11-PRECIPITATION HEAT TREAT AFTER
FORMING. HOLD AT 900°F ± 10°F FOR
ONE HOUR, AIR COOL .

12-HARDNESS EQUIV TO ROCKWELL C48 MIN.

13-TYPE OF ENDS:- ONE CLOSED AND GROUND.
ONE CLOSED, FLARED AND
GROUND.

14-PROTECTIVE FINISH:- 5.4.1 OF MIL-STD-171.

15-SPRING REQUIREMENTS APPLY AFTER
COMPRESSING TO SOLID LENGTH.



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
---	PRODUCTION RELEASE ERRW252013	820614	<i>[Signature]</i>
A	NOR W250011/82-04-13 (ECP W353120/83-07-07)	83-11-04	<i>[Signature]</i>
B	NOR W253258/82-12-30	840904	<i>[Signature]</i>
C	NOR W450030/84-11-15	850402	<i>[Signature]</i>
D	NOR W5S2030/85-05-25	850731	<i>[Signature]</i>

9349115		MI6A2		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 82-02-26		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
NEXT ASSY		USED ON		YP		TOLERANCES ON DECIMALS ±		DRAFTSMAN	MM	CHECKER	DEW
				TS		FRACTIONS ± ANGLES ±		ENGR	<i>[Signature]</i>	ENGR	
				EL2				ENGR	<i>[Signature]</i>	ENGR	
				RA				ENGR		ENGR	
				BH				SPRING, DISCONNECT SIZE C FSCM NO. 19200 9349116 SCALE 10/1 UNIT WT. SHEET 1 OF 1			
				RH							
APPLICATION											